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Clark

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(45) **Date of Patent: Mar. 6, 2007**

(54) **METHODS AND APPARATUS FOR MONITORING AND CONDITIONING STRIP MATERIAL**

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(73) Assignee: **The Bradbury Company, Inc.**, Moundridge, KS (US)

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(51) **Int. Cl.**
B21D 3/02 (2006.01)

(52) **U.S. Cl.** **72/9.1**; 72/8.3; 72/11.7; 72/164

(58) **Field of Classification Search** 72/11.1, 72/7.4, 8.3, 164, 165, 160, 9.1, 11.7
See application file for complete search history.

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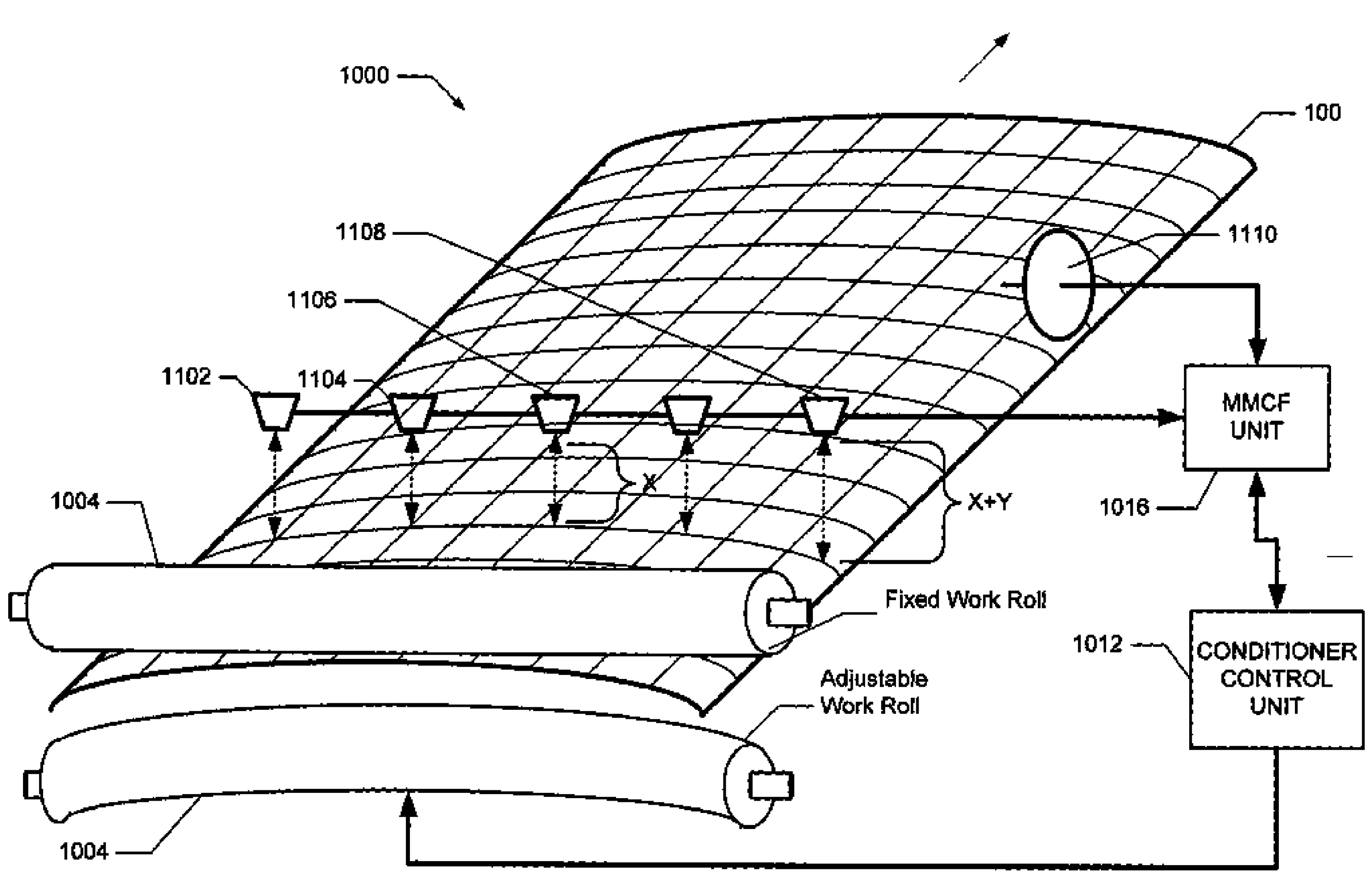
Primary Examiner—Daniel C. Crane

(57) **ABSTRACT**

Methods and an apparatus for monitoring and conditioning strip material are disclosed. The disclosed methods and apparatus receive encoder signals and sensor data to monitor a condition of a strip material. If an undesired material condition is detected, a material conditioner is adjusted to achieve a desired material condition. Each time a sheet is cut, flatness data associated with that sheet is recorded. Each time a bundle is finished, certification data associated with that bundle is printed.

73 Claims, 21 Drawing Sheets



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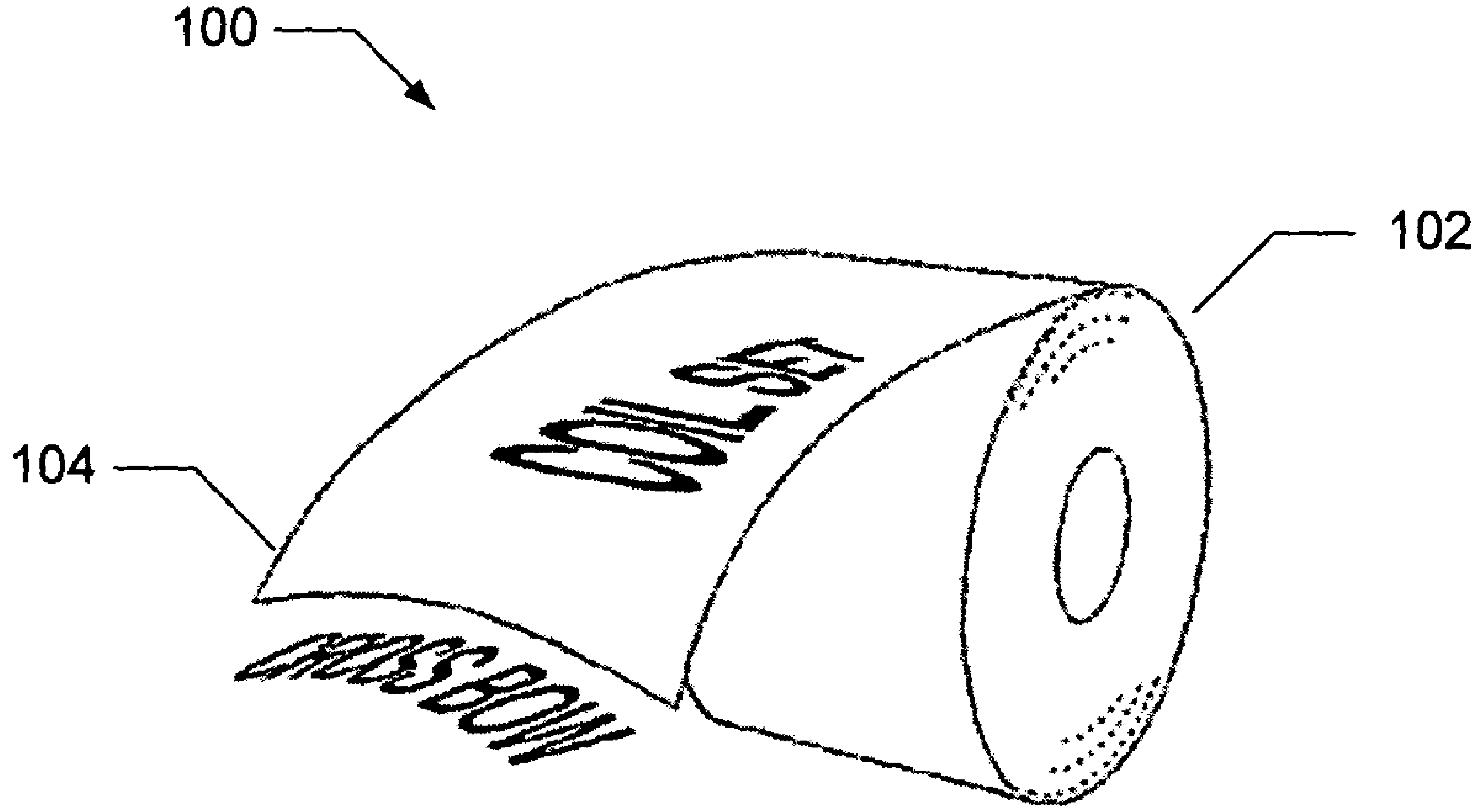


FIG. 1

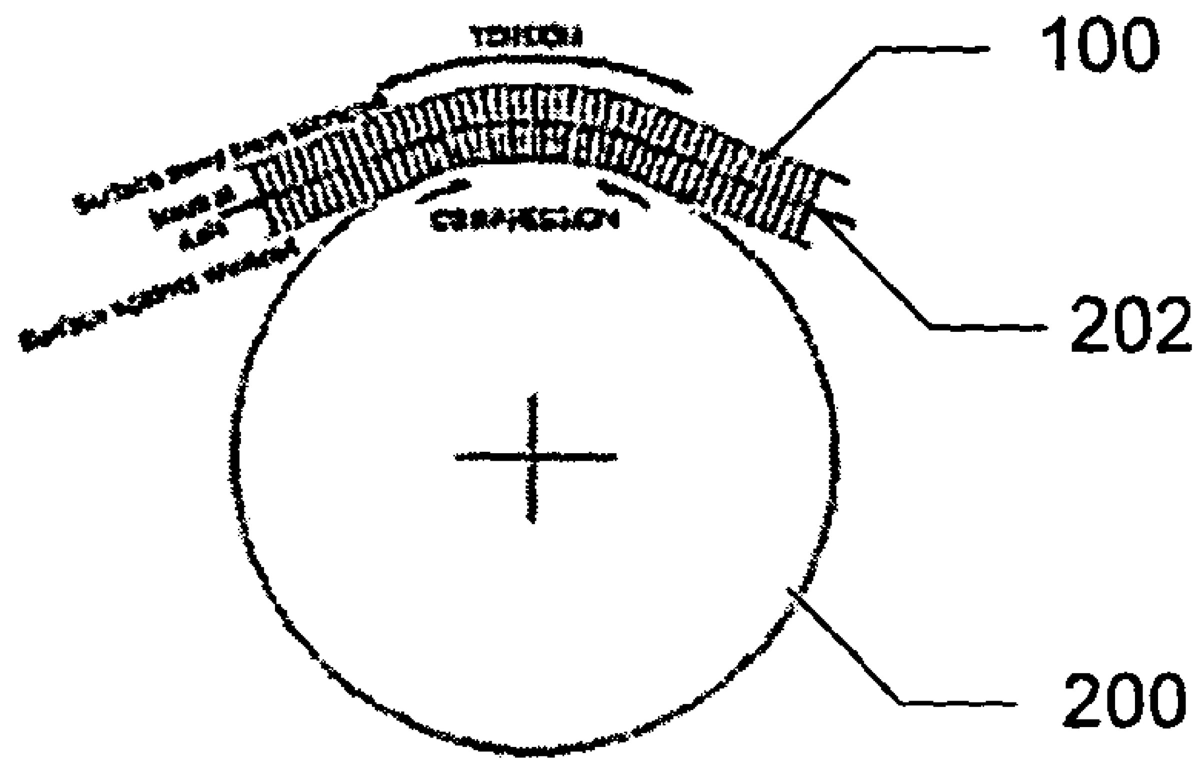


FIG. 2

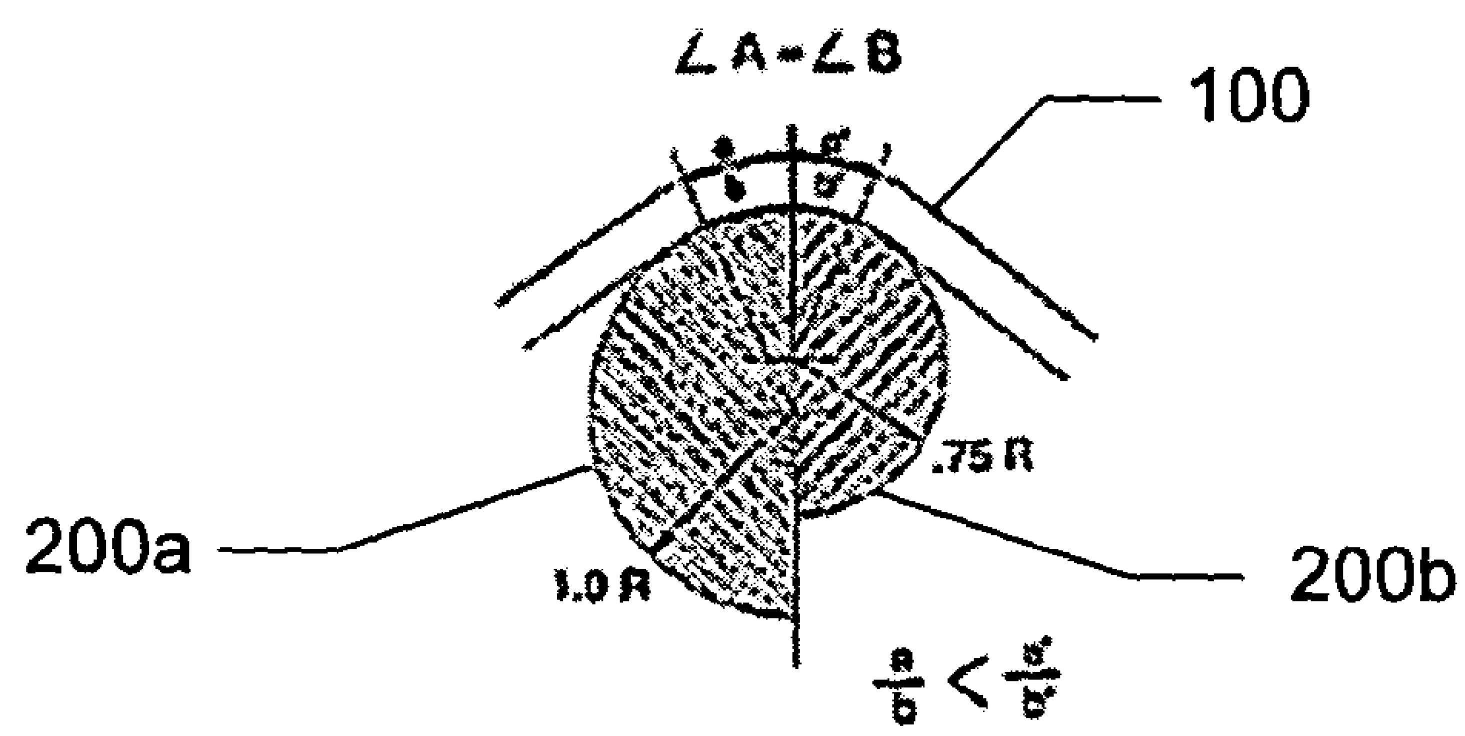


FIG. 3

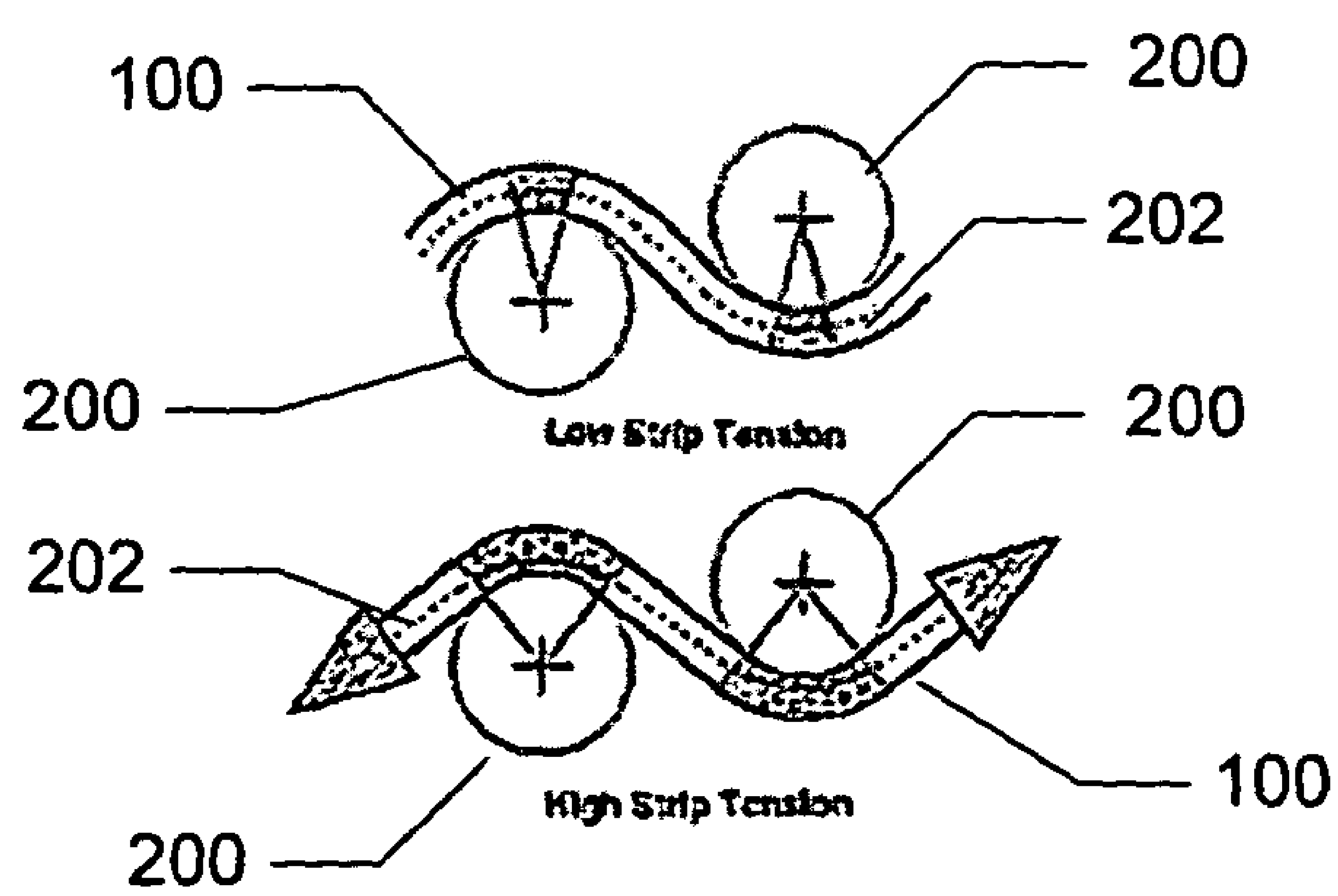


FIG. 4

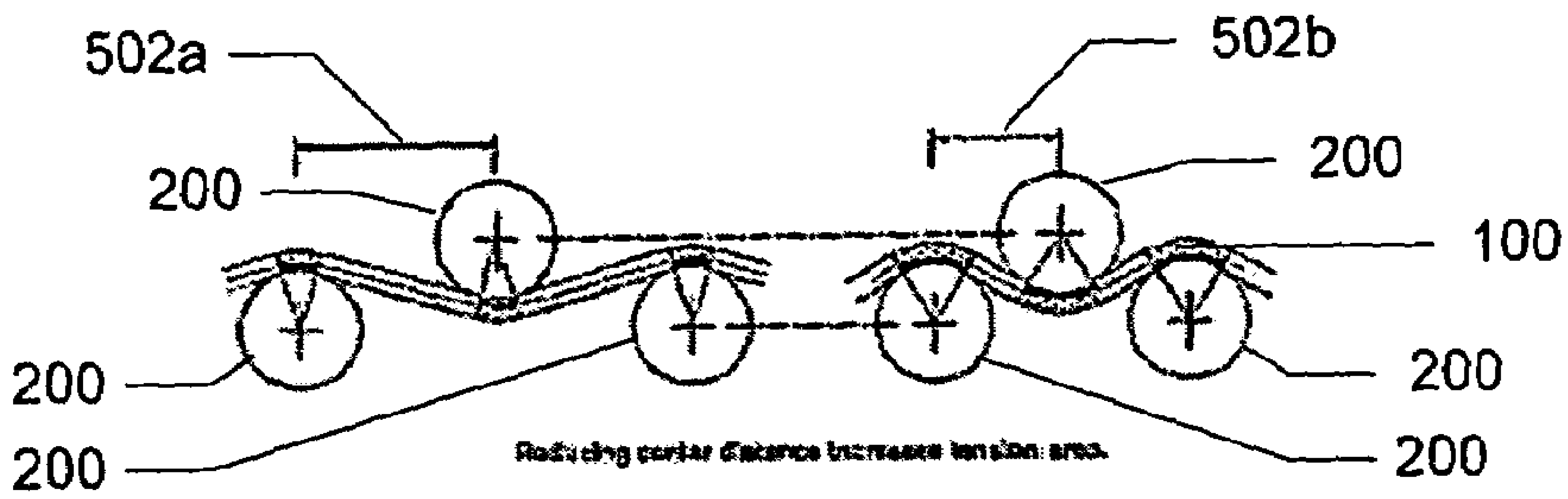

502a
502b
200
200
100
200
200
200
200
Reducing center distance increases tension area.

FIG. 5

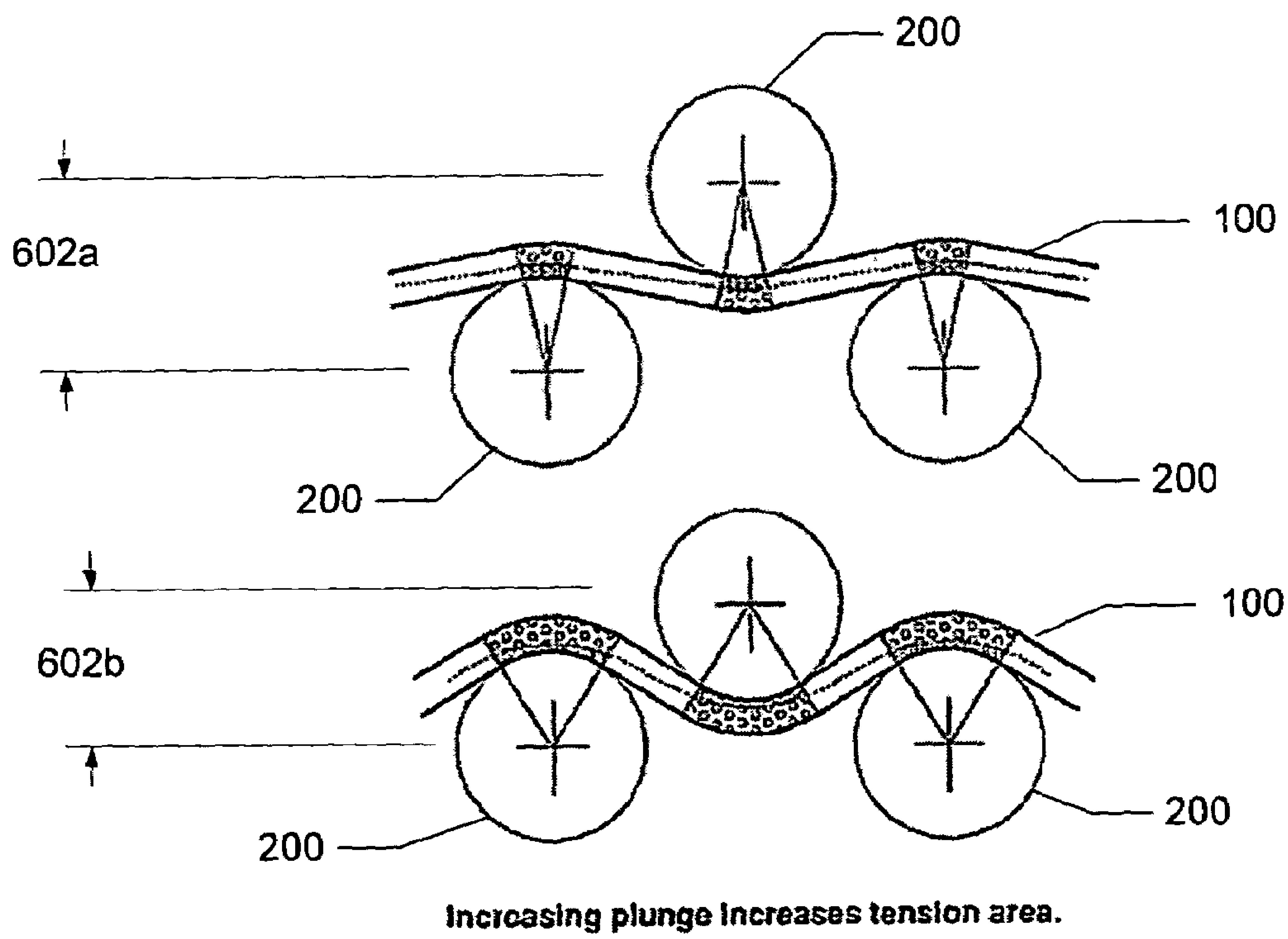

200
602a
100
200
200
602b
100
200
200
Increasing plunge increases tension area.

FIG. 6

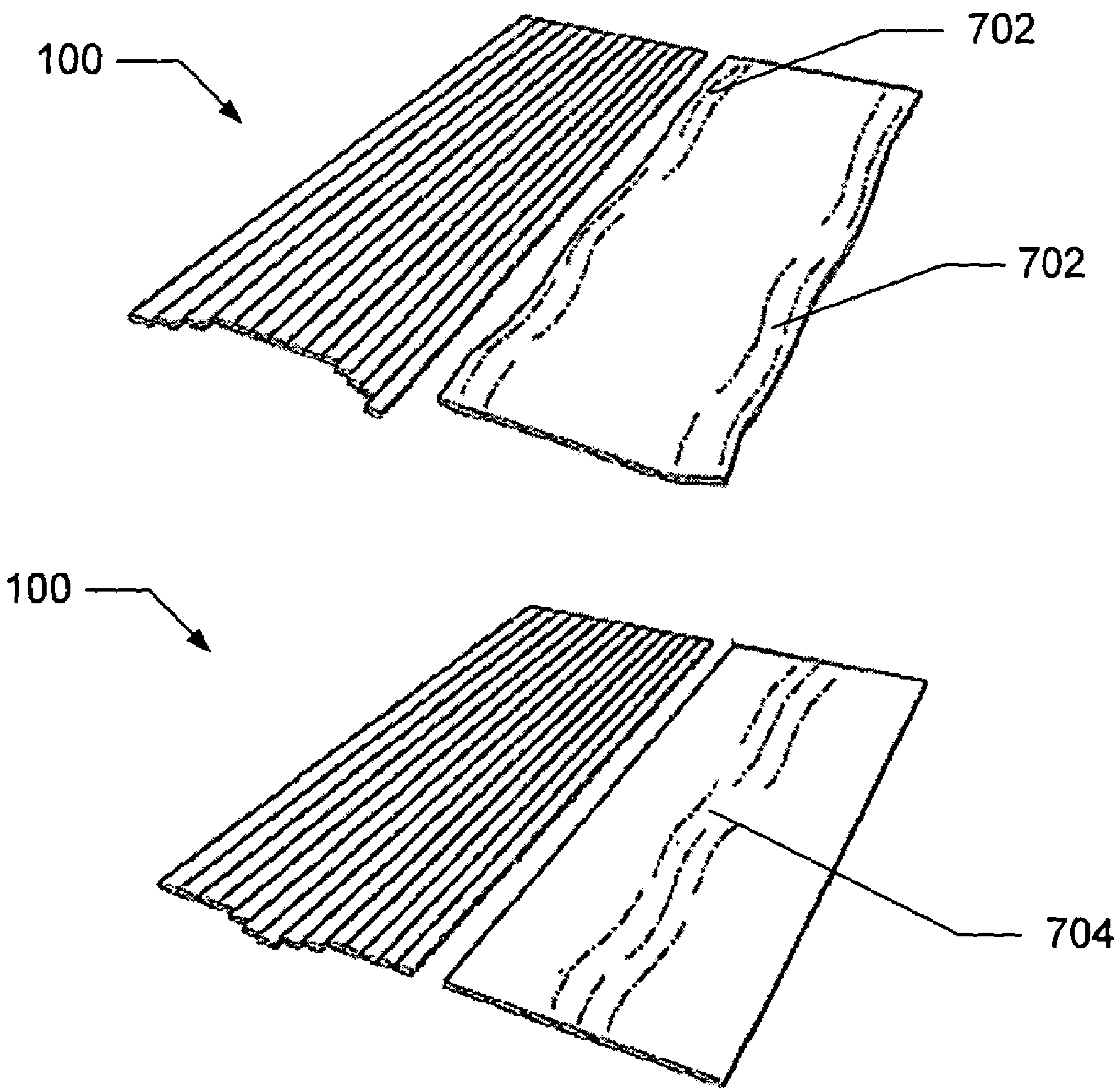


FIG. 7

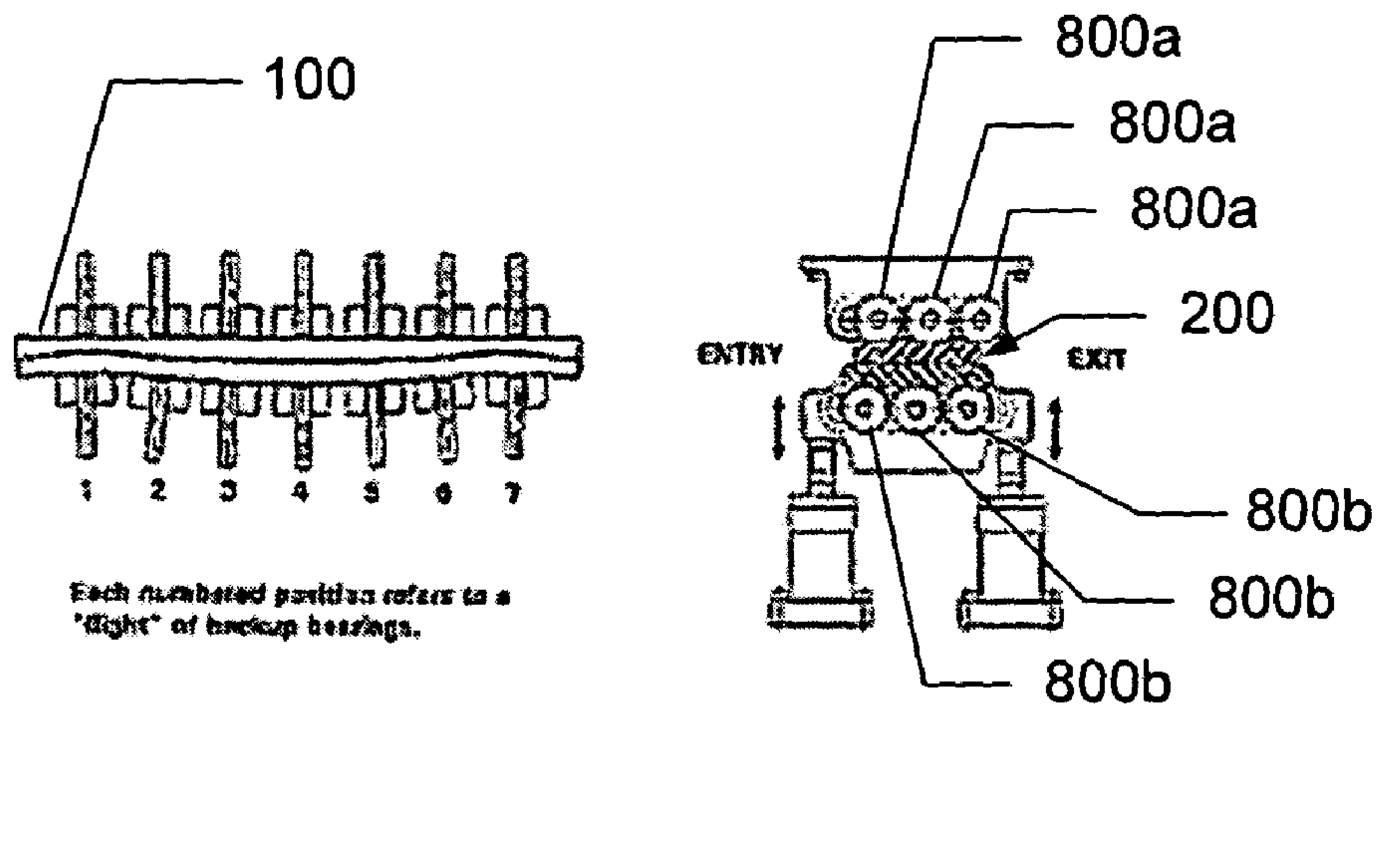

100
1
2
3
4
5
6
7
Each numbered position refers to a "flight" of backup bearings.
800a
800a
800a
200
ENTRY
EXIT
800b
800b
800b

FIG. 8

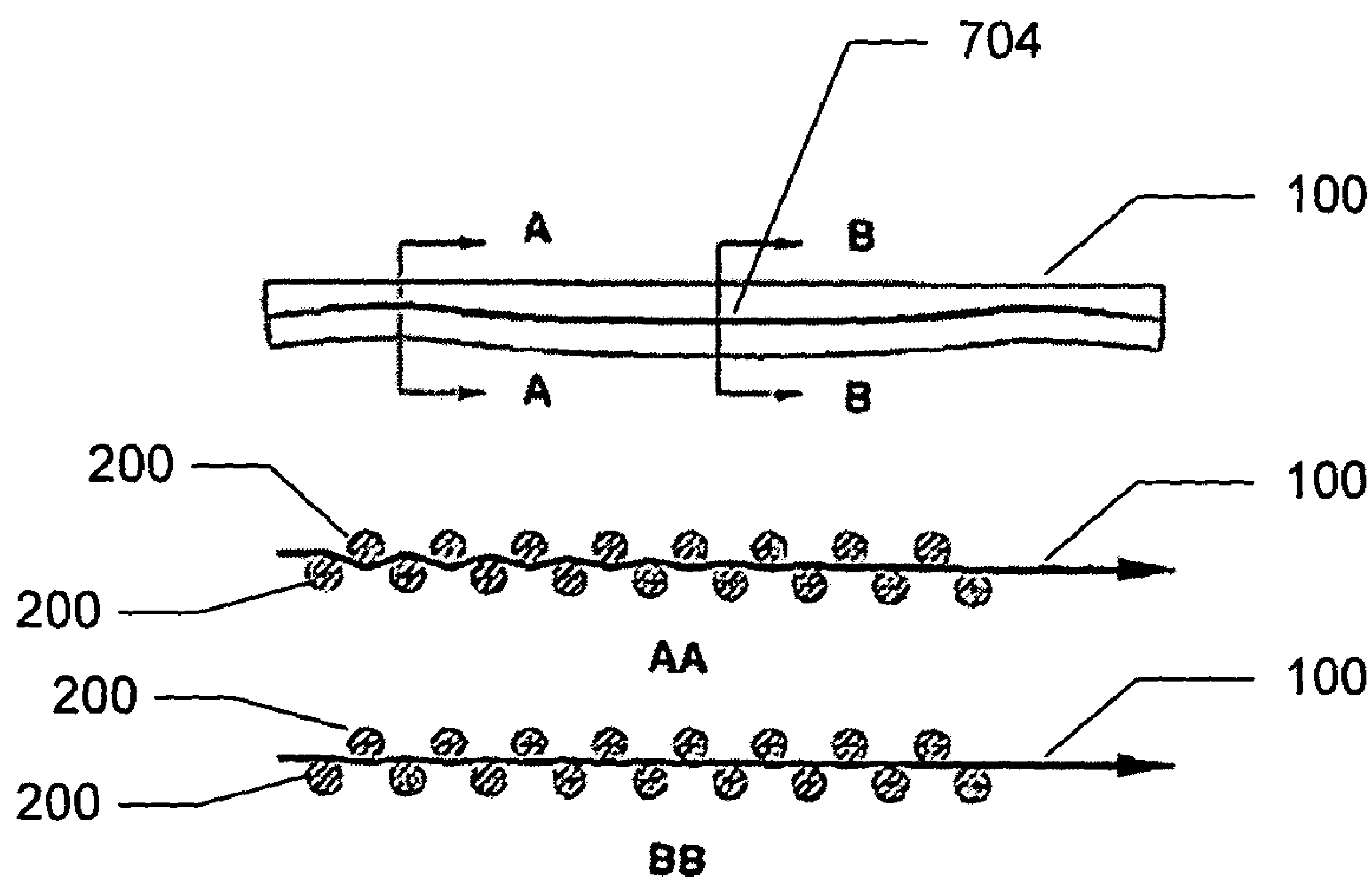

704
A
B
100
A
B
200
100
200
AA
200
100
200
BB

FIG. 9

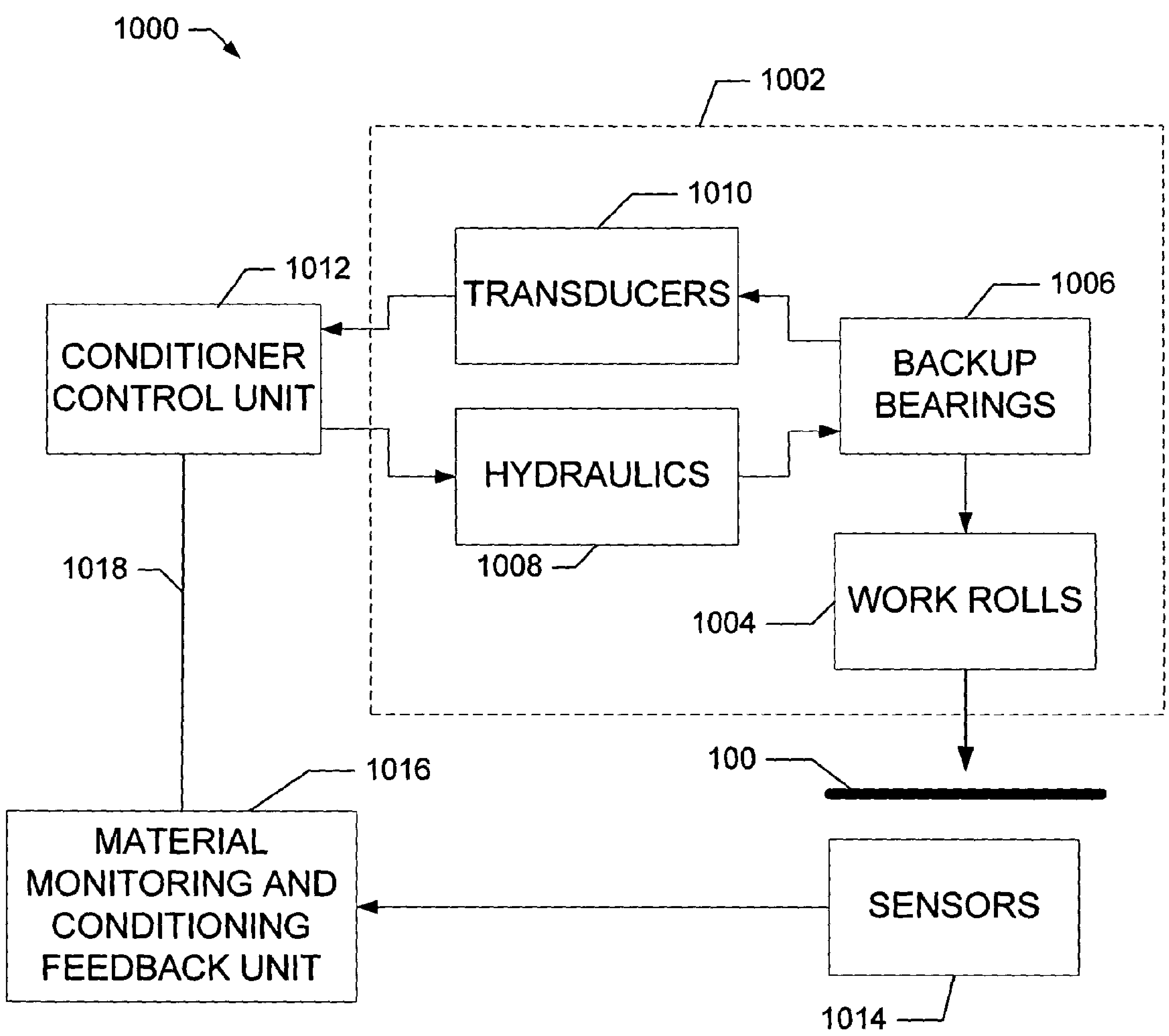

1000
1002
1010
TRANSDUCERS
1012
CONDITIONER CONTROL UNIT
1006
BACKUP BEARINGS
HYDRAULICS
1008
1018
WORK ROLLS
1004
100
1016
MATERIAL MONITORING AND CONDITIONING FEEDBACK UNIT
SENSORS
1014

FIG. 10

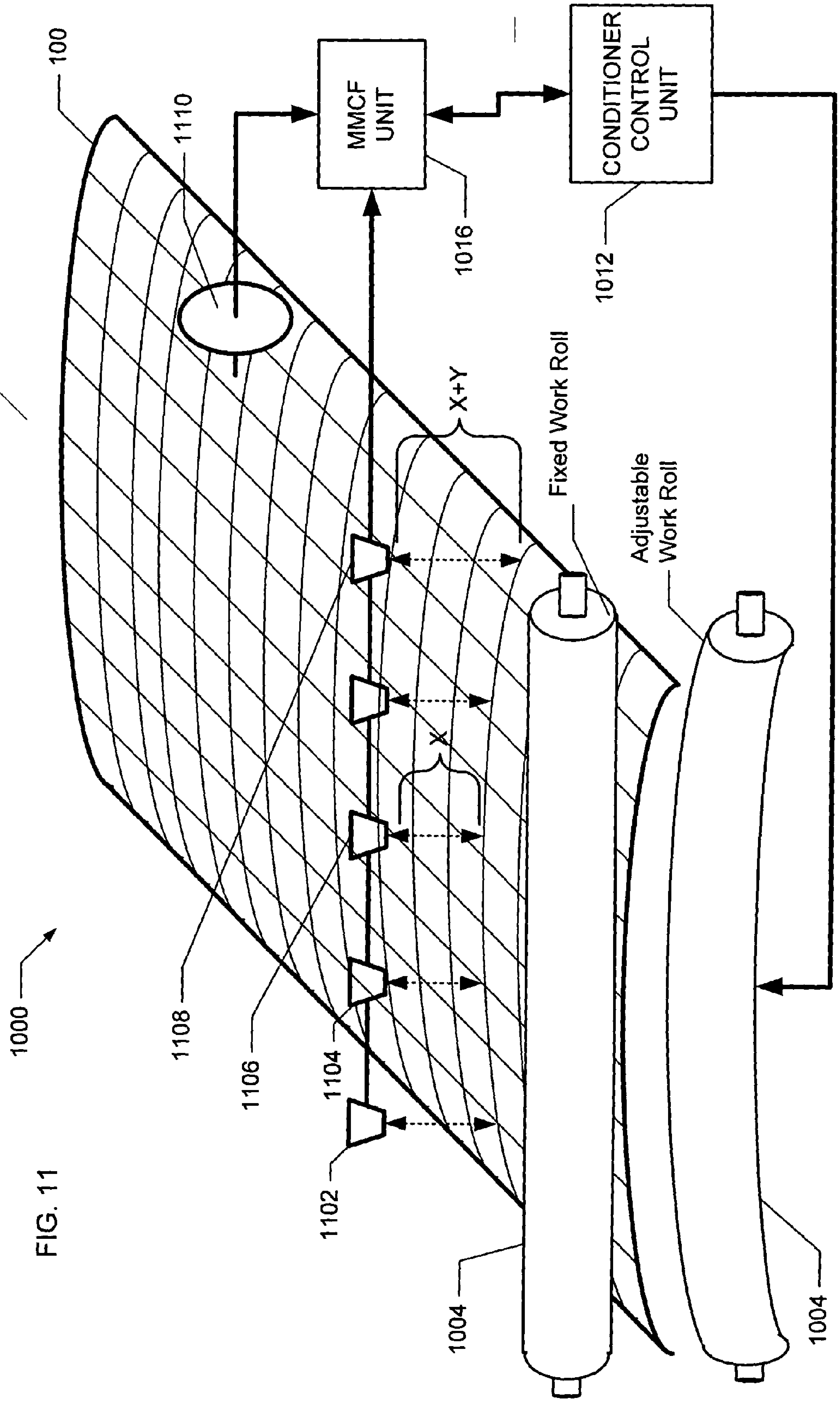

100
1110
MMCF UNIT
CONDITIONER CONTROL UNIT
1016
1012
X+Y
Fixed Work Roll
Adjustable Work Roll
X
1000
1108
1106
1104
1104
1102
1004
1004

FIG. 11

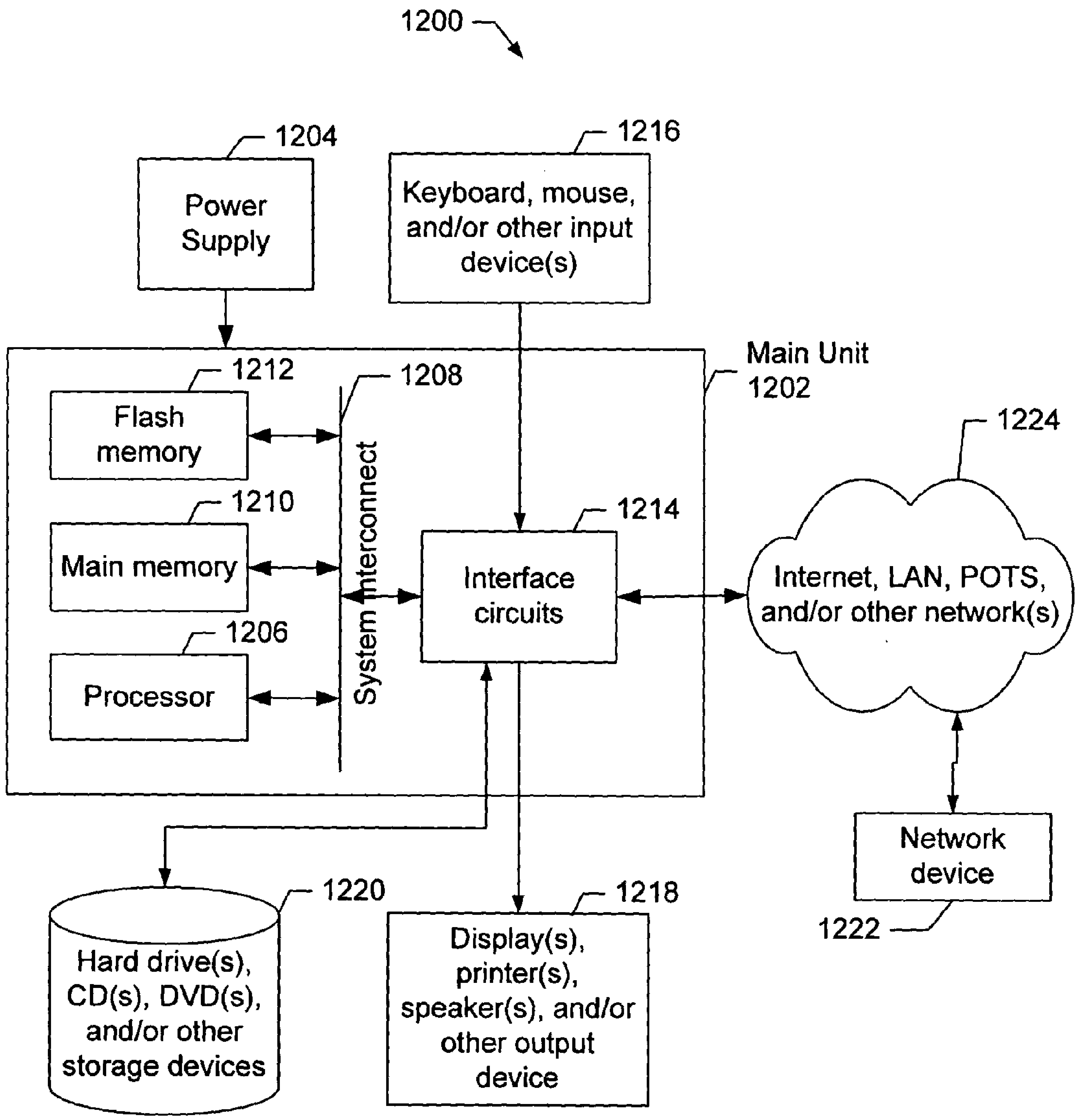

1200
1204
Power Supply
1216
Keyboard, mouse, and/or other input device(s)
Main Unit 1202
1212
Flash memory
1208
System Interconnect
1210
Main memory
1206
Processor
1214
Interface circuits
1224
Internet, LAN, POTS, and/or other network(s)
Network device
1222
1220
Hard drive(s), CD(s), DVD(s), and/or other storage devices
1218
Display(s), printer(s), speaker(s), and/or other output device

FIG. 12

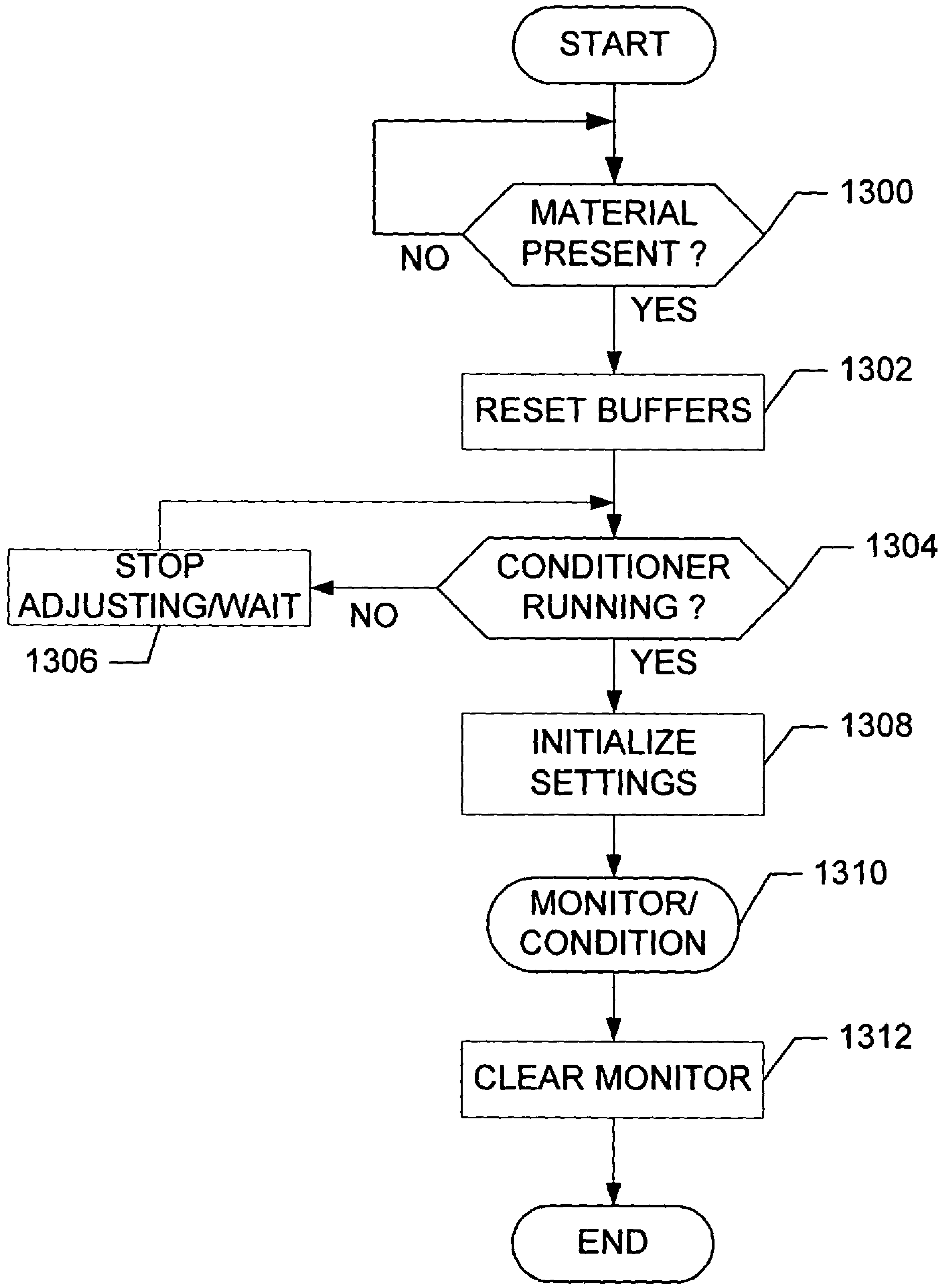

START
MATERIAL PRESENT ?
1300
NO
YES
RESET BUFFERS
1302
CONDITIONER RUNNING ?
1304
NO
STOP ADJUSTING/WAIT
1306
YES
INITIALIZE SETTINGS
1308
MONITOR/ CONDITION
1310
CLEAR MONITOR
1312
END

FIG. 13

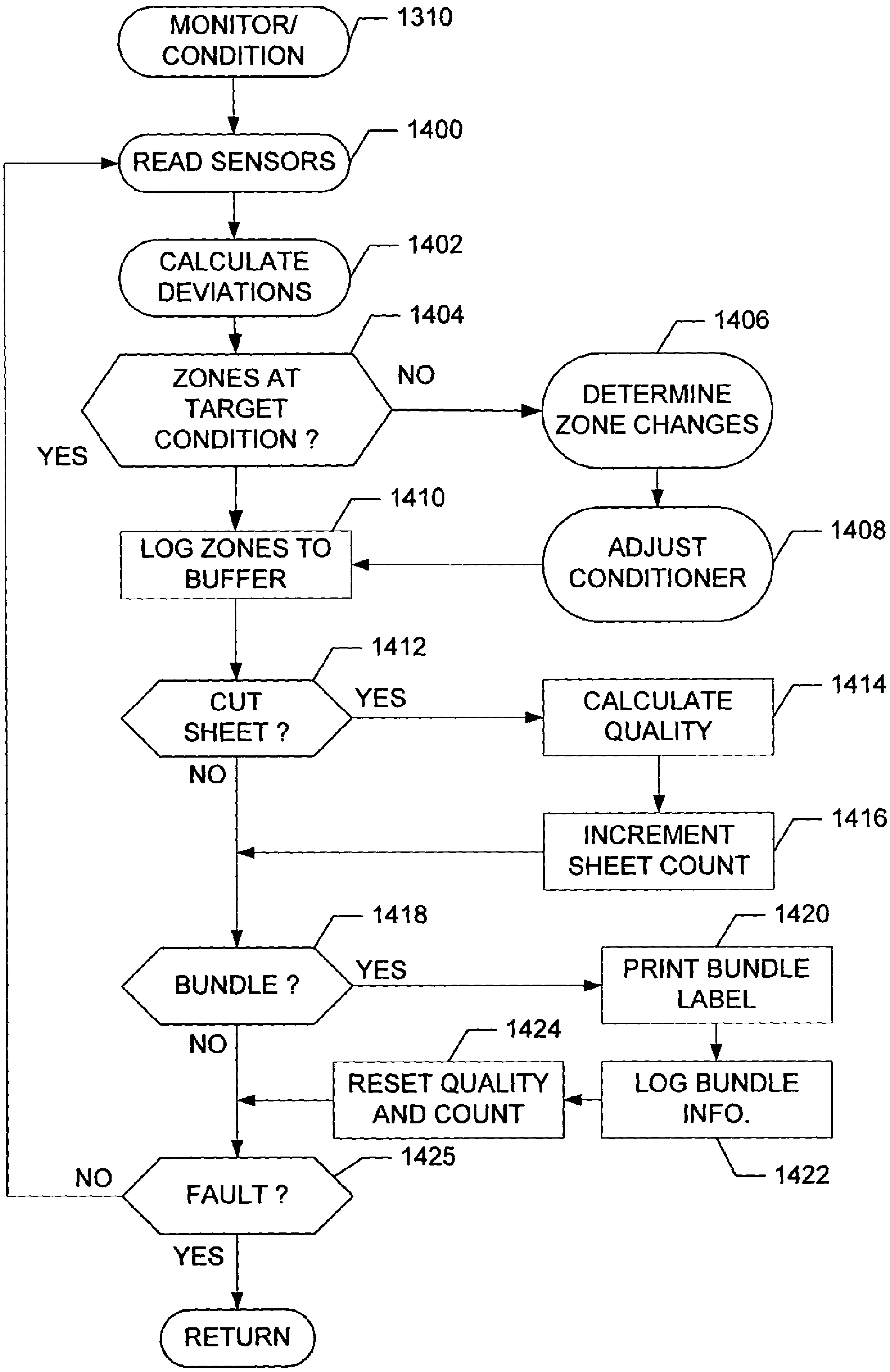

MONITOR/ CONDITION
1310
READ SENSORS
1400
CALCULATE DEVIATIONS
1402
ZONES AT TARGET CONDITION ?
1404
NO
YES
DETERMINE ZONE CHANGES
1406
LOG ZONES TO BUFFER
1410
ADJUST CONDITIONER
1408
CUT SHEET ?
1412
YES
NO
CALCULATE QUALITY
1414
INCREMENT SHEET COUNT
1416
BUNDLE ?
1418
YES
NO
PRINT BUNDLE LABEL
1420
RESET QUALITY AND COUNT
1424
LOG BUNDLE INFO.
1422
FAULT ?
1425
NO
YES
RETURN

FIG. 14

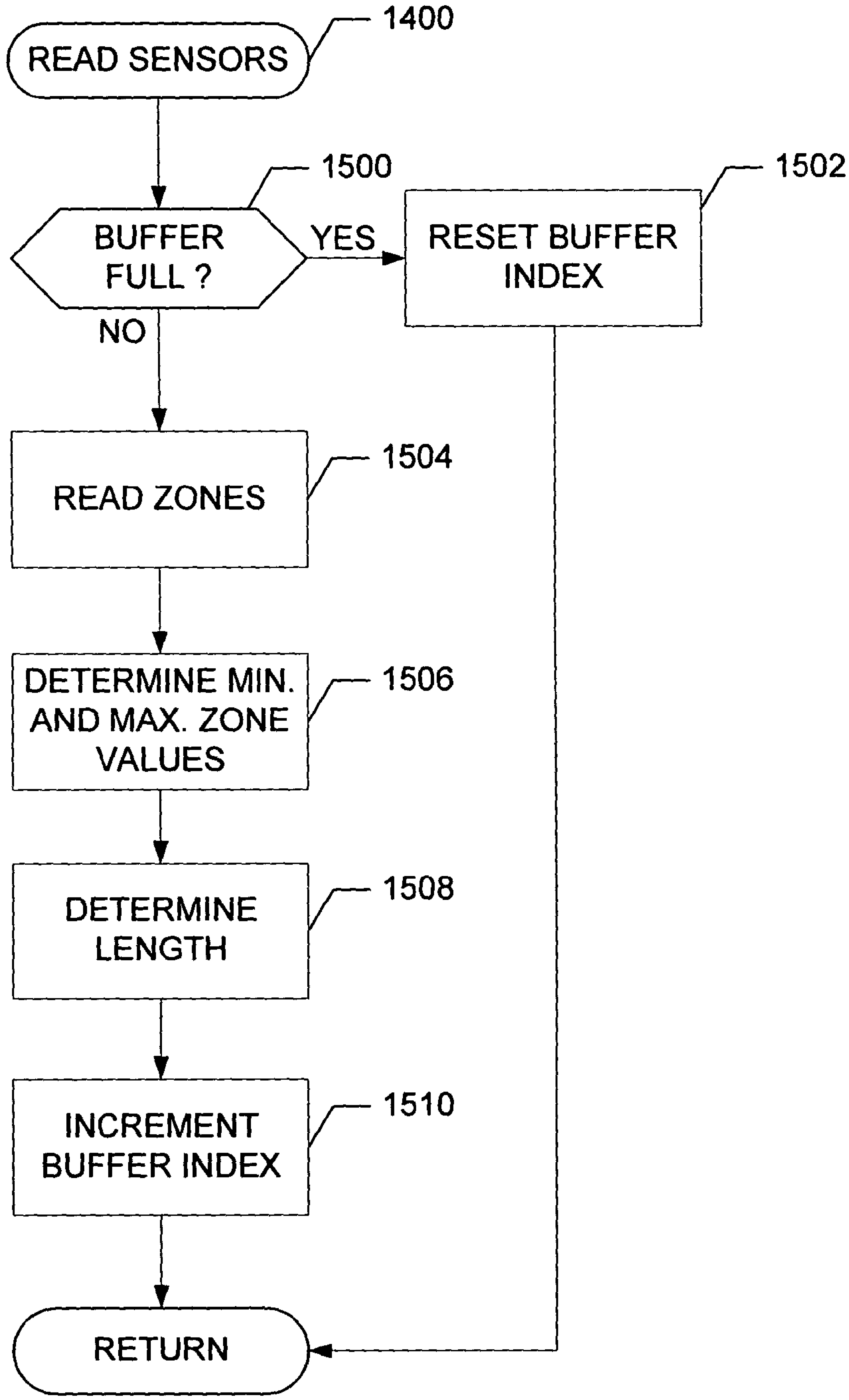

READ SENSORS
1400
BUFFER FULL ?
1500
YES
RESET BUFFER INDEX
1502
NO
READ ZONES
1504
DETERMINE MIN. AND MAX. ZONE VALUES
1506
DETERMINE LENGTH
1508
INCREMENT BUFFER INDEX
1510
RETURN

FIG. 15

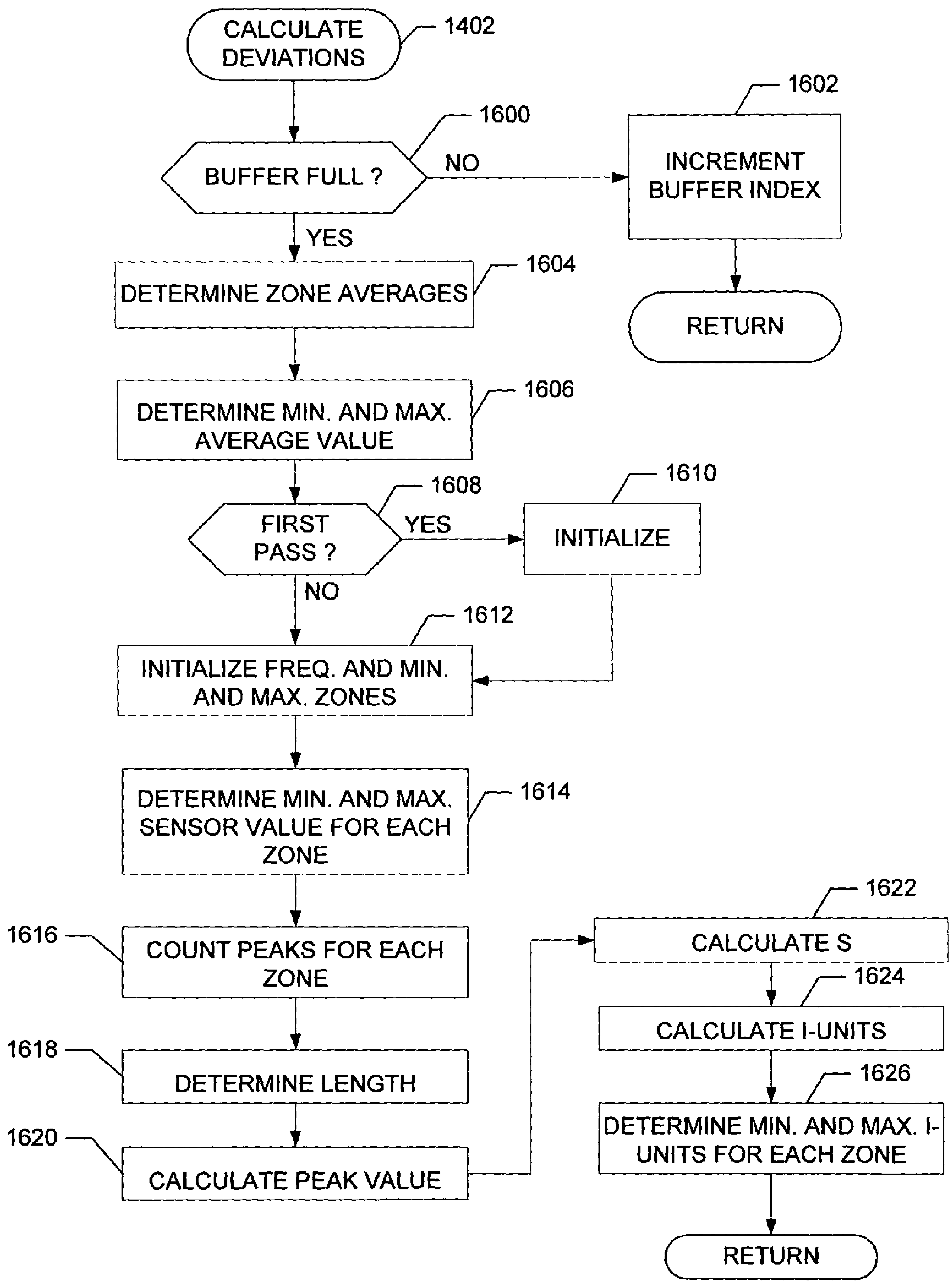

CALCULATE DEVIATIONS
1402
BUFFER FULL ?
1600
NO
INCREMENT BUFFER INDEX
1602
RETURN
YES
DETERMINE ZONE AVERAGES
1604
DETERMINE MIN. AND MAX. AVERAGE VALUE
1606
FIRST PASS ?
1608
YES
INITIALIZE
1610
NO
INITIALIZE FREQ. AND MIN. AND MAX. ZONES
1612
DETERMINE MIN. AND MAX. SENSOR VALUE FOR EACH ZONE
1614
1616
COUNT PEAKS FOR EACH ZONE
1618
DETERMINE LENGTH
1620
CALCULATE PEAK VALUE
CALCULATE S
1622
CALCULATE I-UNITS
1624
DETERMINE MIN. AND MAX. I-UNITS FOR EACH ZONE
1626
RETURN

FIG. 16

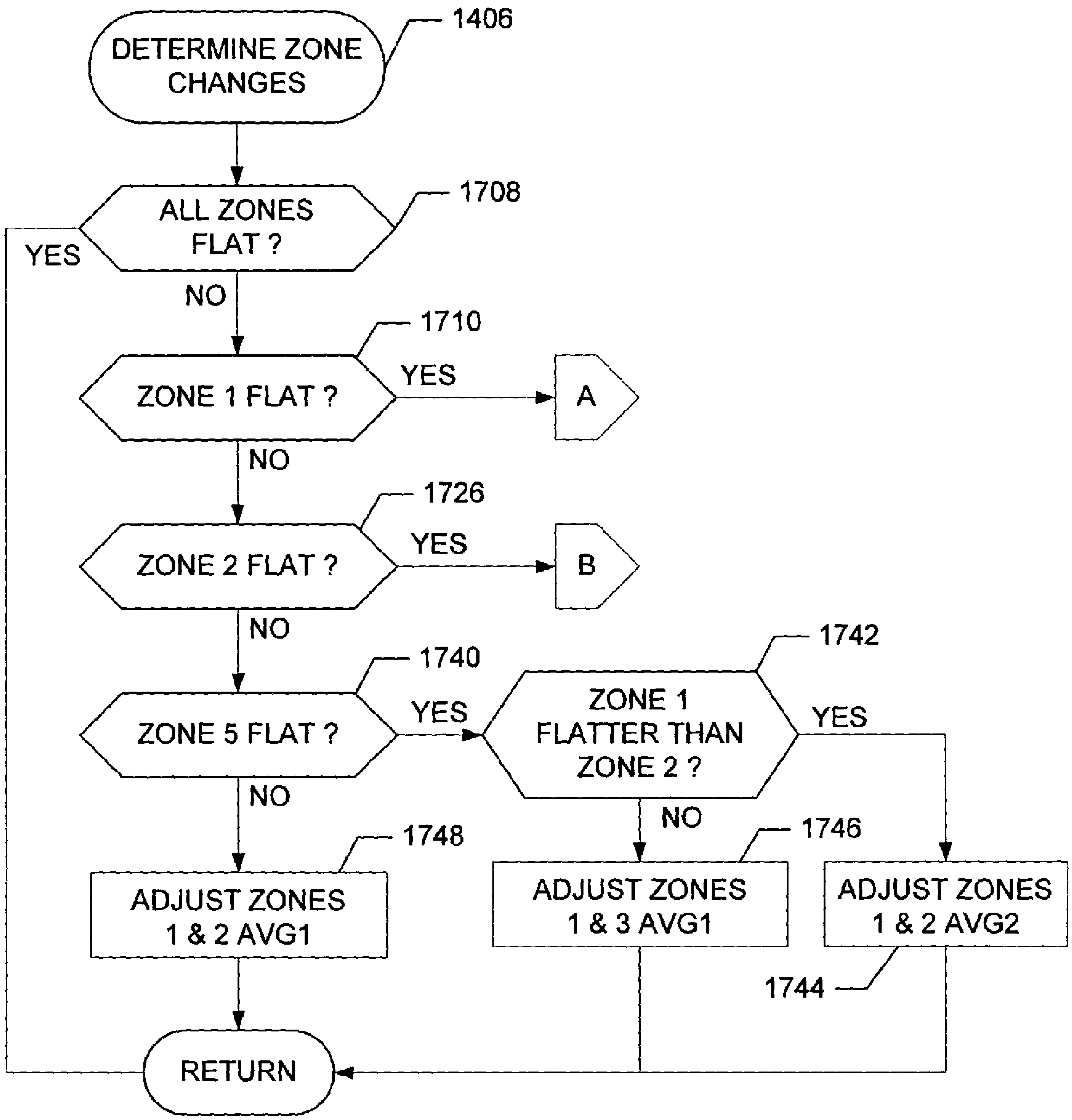

DETERMINE ZONE CHANGES
1406
ALL ZONES FLAT ?
1708
YES
NO
ZONE 1 FLAT ?
1710
YES
A
NO
ZONE 2 FLAT ?
1726
YES
B
NO
ZONE 5 FLAT ?
1740
YES
ZONE 1 FLATTER THAN ZONE 2 ?
1742
YES
NO
1748
ADJUST ZONES 1 & 2 AVG1
1746
ADJUST ZONES 1 & 3 AVG1
ADJUST ZONES 1 & 2 AVG2
1744
RETURN

FIG. 17

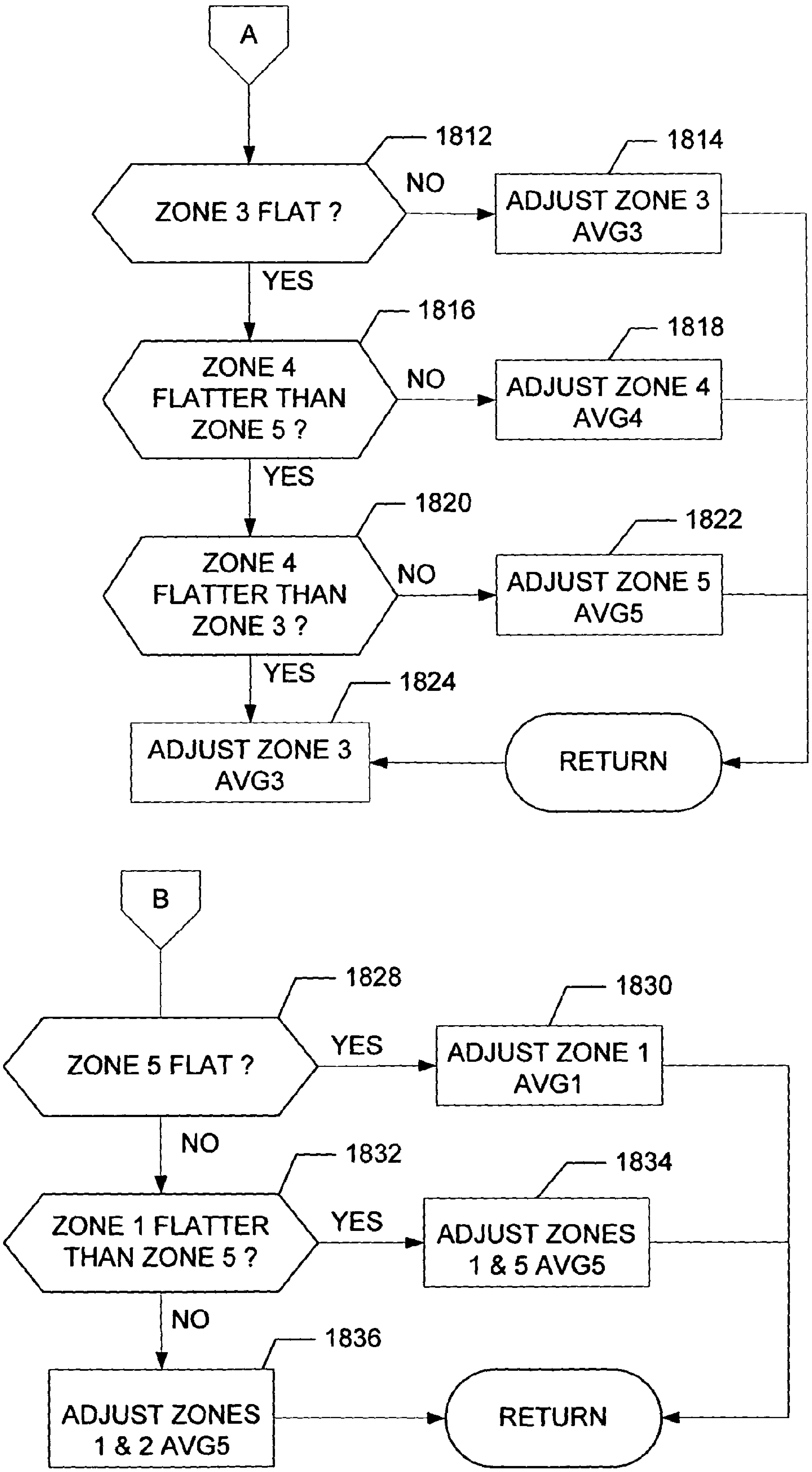

A
1812
ZONE 3 FLAT ?
NO
YES
1814
ADJUST ZONE 3 AVG3
1816
ZONE 4 FLATTER THAN ZONE 5 ?
NO
YES
1818
ADJUST ZONE 4 AVG4
1820
ZONE 4 FLATTER THAN ZONE 3 ?
NO
YES
1822
ADJUST ZONE 5 AVG5
1824
ADJUST ZONE 3 AVG3
RETURN
B
1828
ZONE 5 FLAT ?
YES
NO
1830
ADJUST ZONE 1 AVG1
1832
ZONE 1 FLATTER THAN ZONE 5 ?
YES
NO
1834
ADJUST ZONES 1 & 5 AVG5
1836
ADJUST ZONES 1 & 2 AVG5
RETURN

FIG. 18

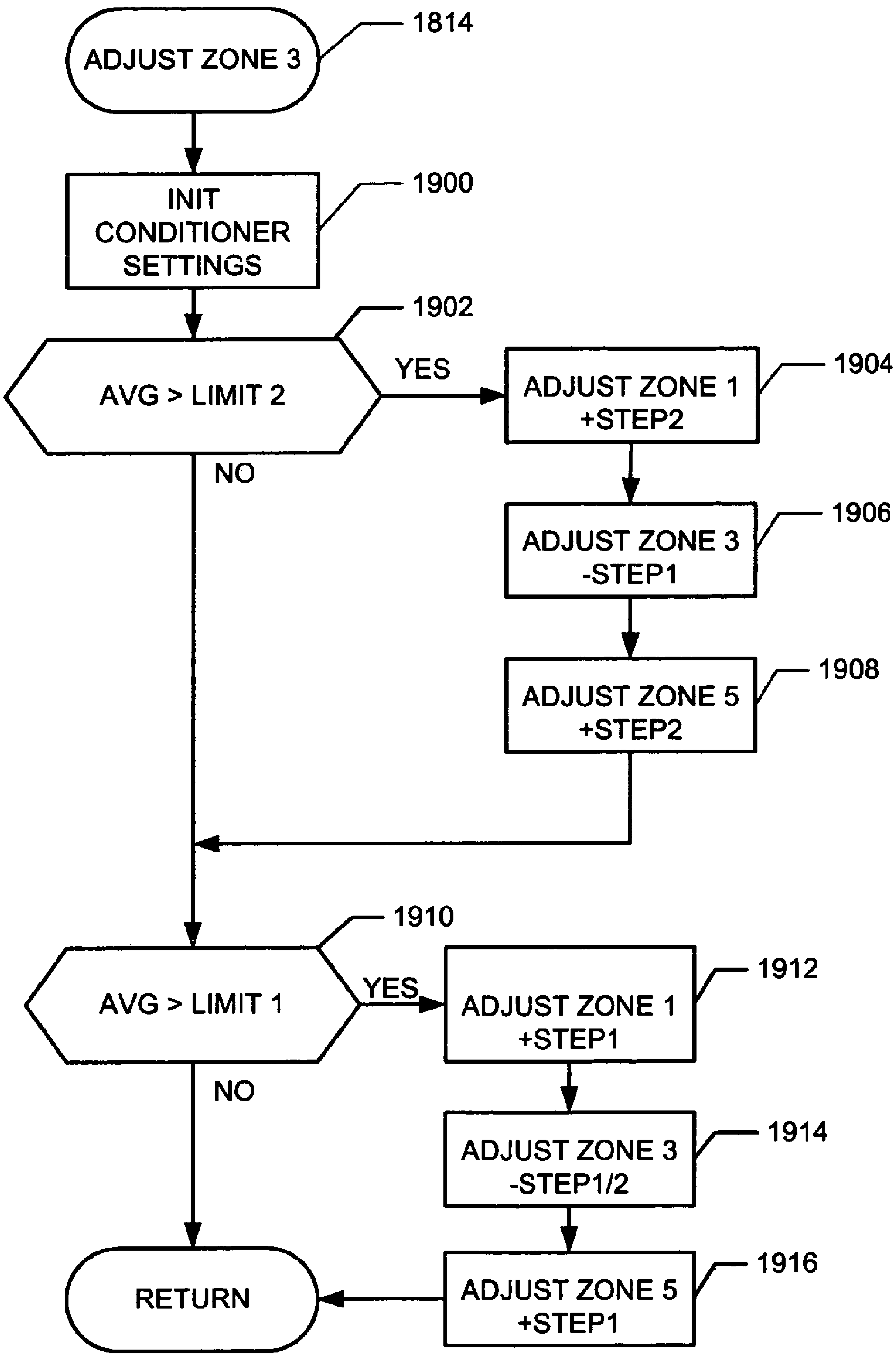

ADJUST ZONE 3
1814
INIT CONDITIONER SETTINGS
1900
1902
AVG > LIMIT 2
YES
NO
ADJUST ZONE 1 +STEP2
1904
ADJUST ZONE 3 -STEP1
1906
ADJUST ZONE 5 +STEP2
1908
1910
AVG > LIMIT 1
YES
NO
ADJUST ZONE 1 +STEP1
1912
ADJUST ZONE 3 -STEP1/2
1914
RETURN
ADJUST ZONE 5 +STEP1
1916

FIG. 19

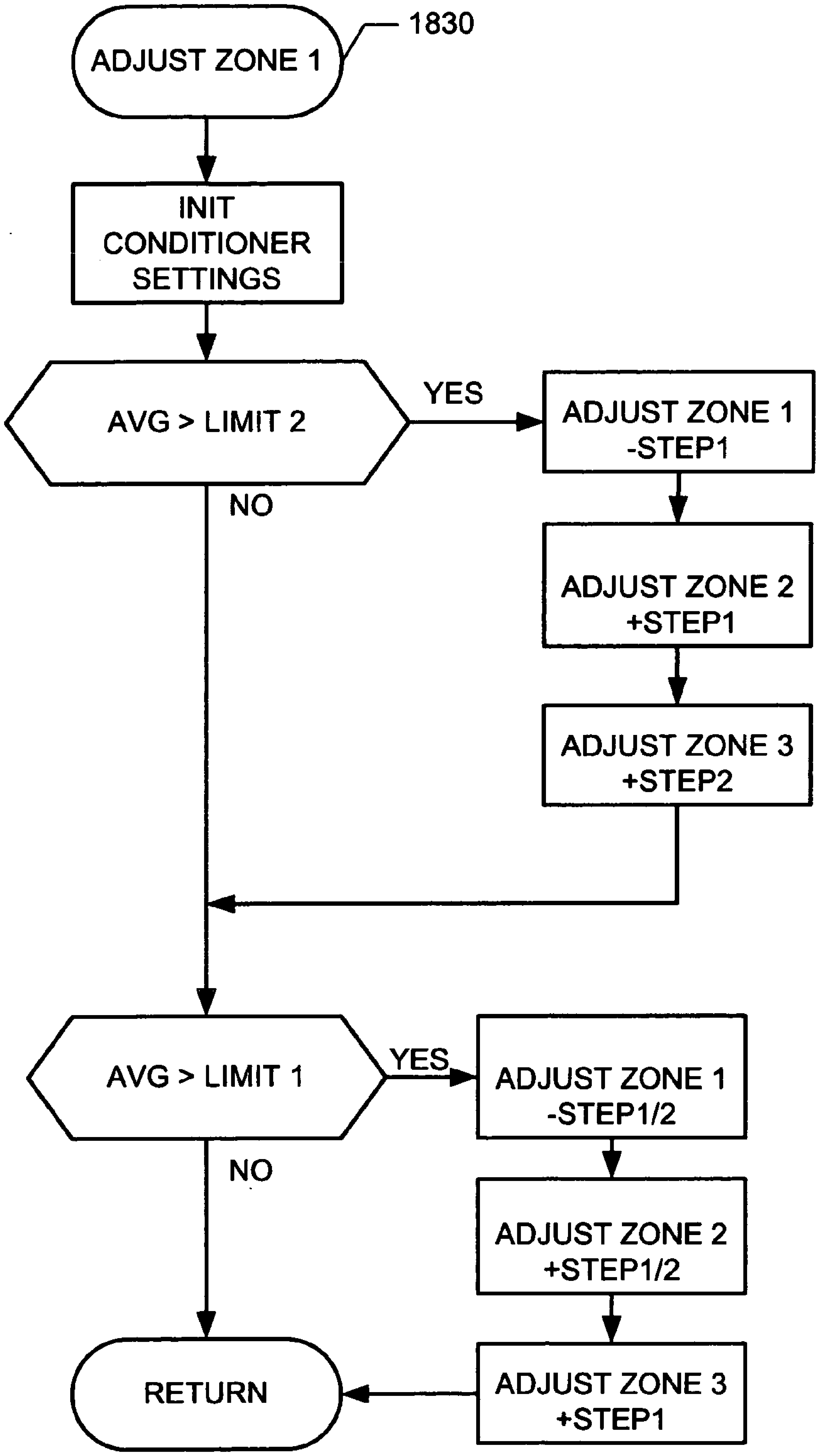
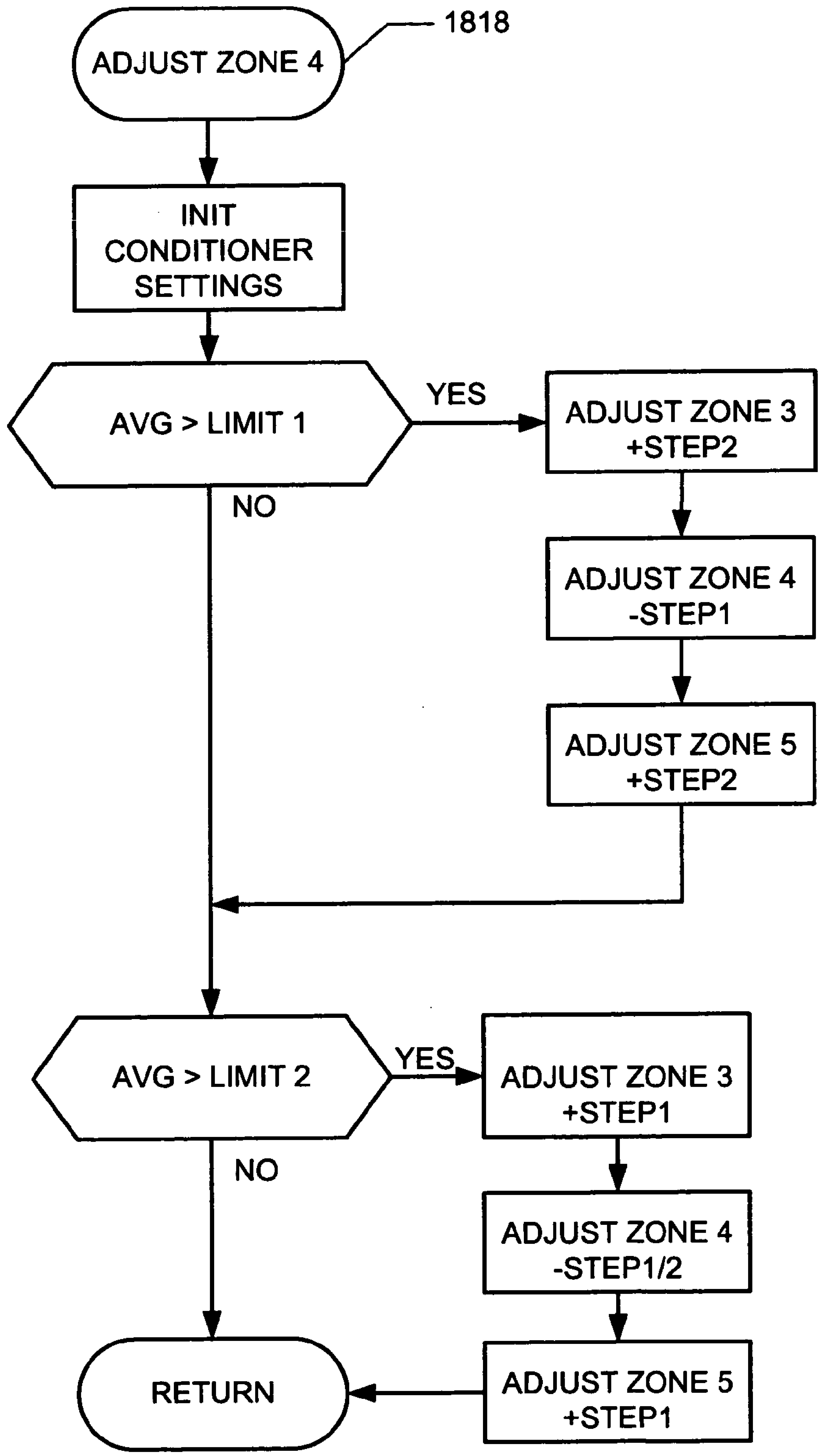

1830
ADJUST ZONE 1
INIT CONDITIONER SETTINGS
AVG > LIMIT 2
YES
NO
ADJUST ZONE 1 -STEP1
ADJUST ZONE 2 +STEP1
ADJUST ZONE 3 +STEP2
AVG > LIMIT 1
YES
NO
ADJUST ZONE 1 -STEP1/2
ADJUST ZONE 2 +STEP1/2
ADJUST ZONE 3 +STEP1
RETURN

FIG. 20



1818
ADJUST ZONE 4
INIT CONDITIONER SETTINGS
AVG > LIMIT 1
YES
NO
ADJUST ZONE 3 +STEP2
ADJUST ZONE 4 -STEP1
ADJUST ZONE 5 +STEP2
AVG > LIMIT 2
YES
NO
ADJUST ZONE 3 +STEP1
ADJUST ZONE 4 -STEP1/2
ADJUST ZONE 5 +STEP1
RETURN

FIG. 21

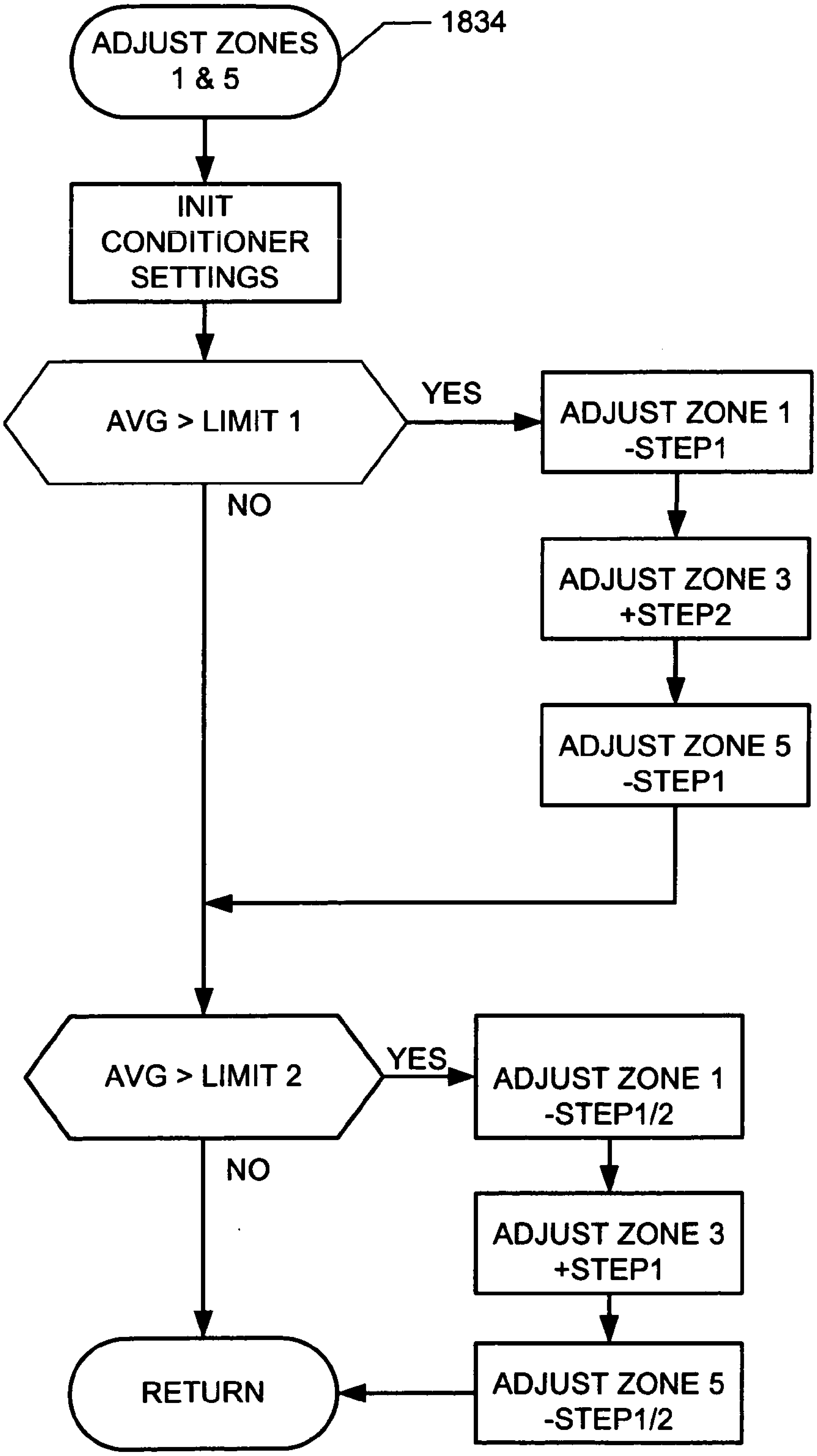

1834
ADJUST ZONES 1 & 5
INIT CONDITIONER SETTINGS
AVG > LIMIT 1
YES
NO
ADJUST ZONE 1 -STEP1
ADJUST ZONE 3 +STEP2
ADJUST ZONE 5 -STEP1
AVG > LIMIT 2
YES
NO
ADJUST ZONE 1 -STEP1/2
ADJUST ZONE 3 +STEP1
ADJUST ZONE 5 -STEP1/2
RETURN

FIG. 22

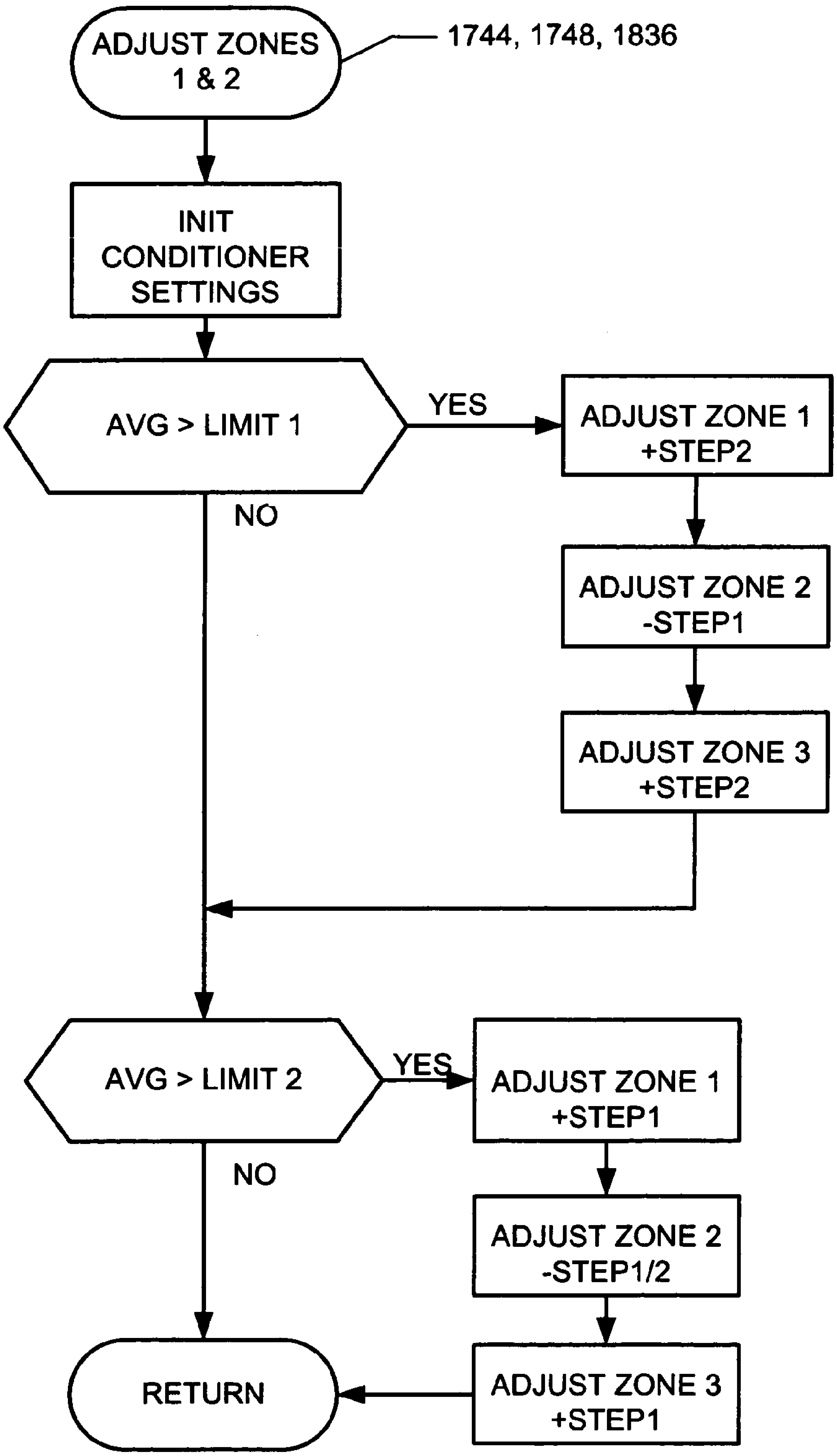

ADJUST ZONES 1 & 2
1744, 1748, 1836
INIT CONDITIONER SETTINGS
AVG > LIMIT 1
YES
NO
ADJUST ZONE 1 +STEP2
ADJUST ZONE 2 -STEP1
ADJUST ZONE 3 +STEP2
AVG > LIMIT 2
YES
NO
ADJUST ZONE 1 +STEP1
ADJUST ZONE 2 -STEP1/2
ADJUST ZONE 3 +STEP1
RETURN

FIG. 23

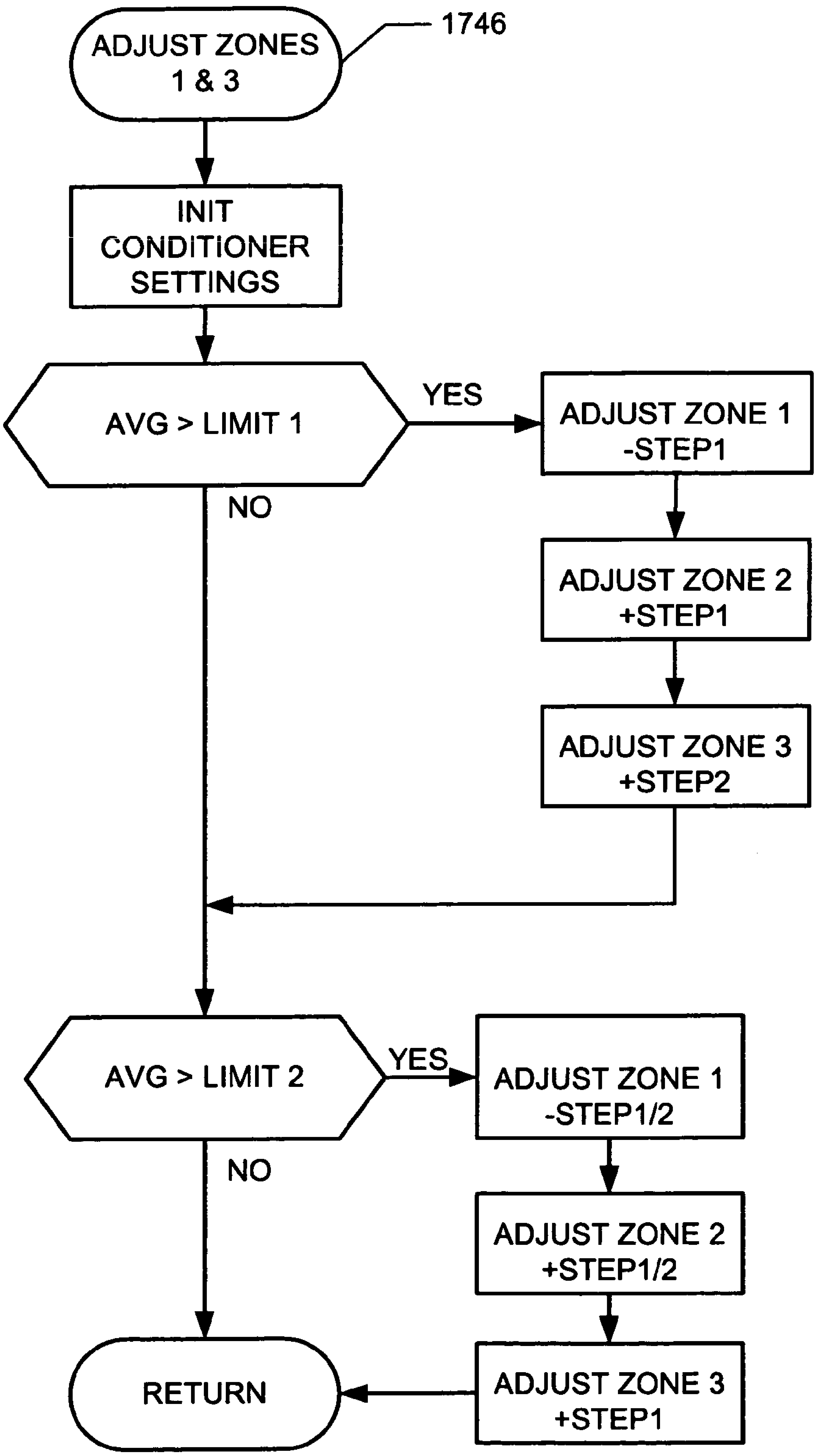
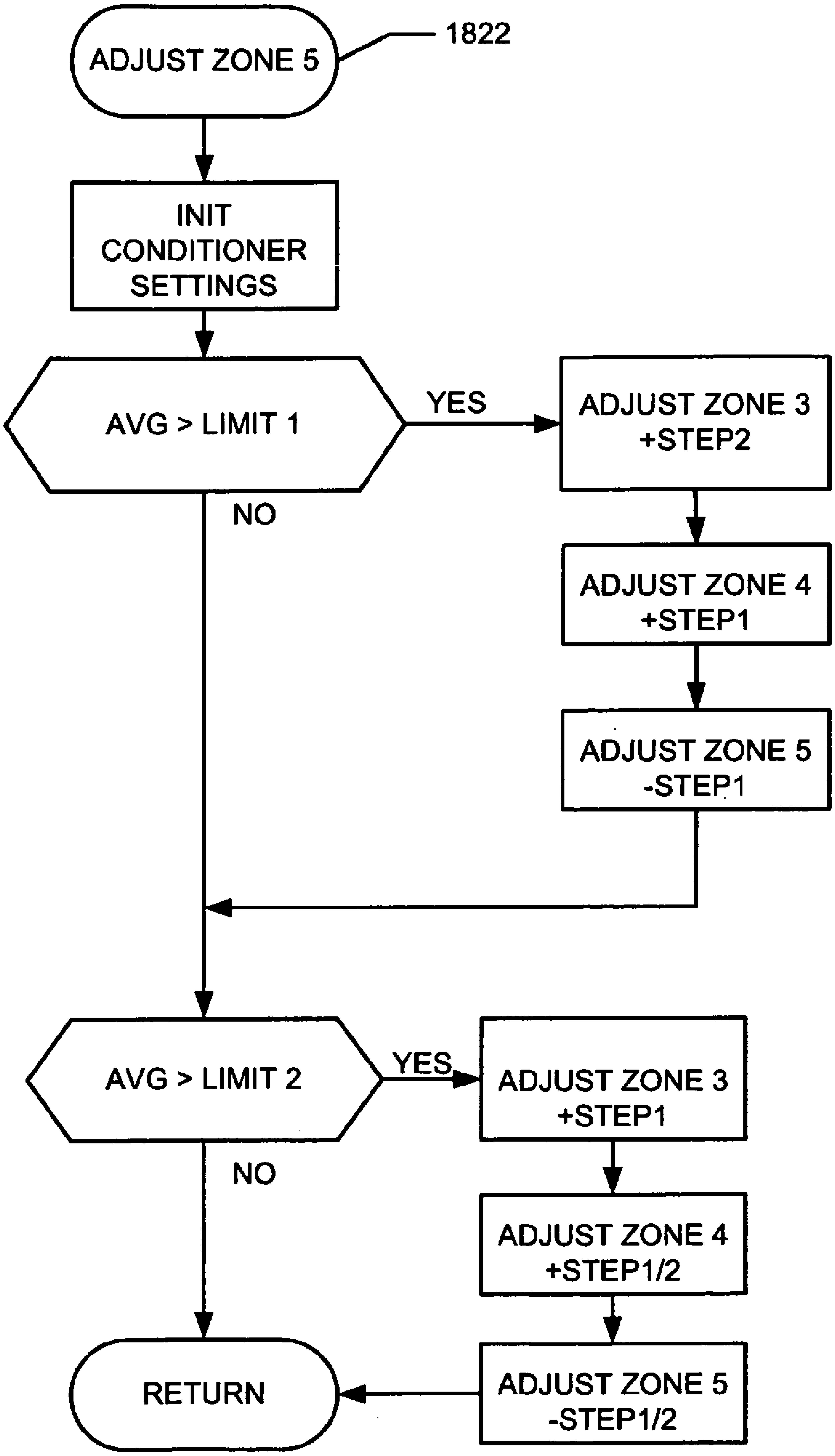

ADJUST ZONES 1 & 3
1746
INIT CONDITIONER SETTINGS
AVG > LIMIT 1
YES
NO
ADJUST ZONE 1 -STEP1
ADJUST ZONE 2 +STEP1
ADJUST ZONE 3 +STEP2
AVG > LIMIT 2
YES
NO
ADJUST ZONE 1 -STEP1/2
ADJUST ZONE 2 +STEP1/2
ADJUST ZONE 3 +STEP1
RETURN

FIG. 24



ADJUST ZONE 5
1822
INIT CONDITIONER SETTINGS
AVG > LIMIT 1
YES
NO
ADJUST ZONE 3 +STEP2
ADJUST ZONE 4 +STEP1
ADJUST ZONE 5 -STEP1
AVG > LIMIT 2
YES
NO
ADJUST ZONE 3 +STEP1
ADJUST ZONE 4 +STEP1/2
ADJUST ZONE 5 -STEP1/2
RETURN

FIG. 25

METHODS AND APPARATUS FOR MONITORING AND CONDITIONING STRIP MATERIAL

TECHNICAL FIELD

The present disclosure pertains to strip material processing and, more particularly, to methods and apparatus for monitoring and conditioning strip material.

BACKGROUND

Many products such as construction panels, beams and garage doors are made from strip material that is pulled from a roll or coil of the strip material and processed using rollforming equipment or machines. A detailed description of a rollforming machine may be found in U.S. Pat. No. 6,434,994, which is incorporated herein by reference in its entirety. A rollforming machine typically removes strip material (e.g., a metal) from a coiled quantity of the strip material and progressively bends and forms the strip material to produce a product profile and, ultimately, a finished product.

Uncoiled rolled metal or strip material may have certain undesirable characteristics such as, for example, coil set, crossbow, buckling along one or both outer edges, mid-edges or a center portion, etc. As a result, the strip material removed from a coil typically requires conditioning (e.g., flattening and/or leveling) prior to subsequent processing in a rollforming machine. Typically, the strip material is conditioned by flattener or a leveler to have a substantially flat condition. However, in some applications it may be desirable to condition the strip material to have a non-flat condition. For example, the strip material may be conditioned to have a particular bowed condition to facilitate a subsequent rollforming process in which the conditioned strip material may be cut, bent, punched, etc. to produce a finished product.

Strip material removed from coils is often conditioned (e.g., flattened) using a leveler, which is a well known type of apparatus. A leveler typically includes a plurality of work rolls. Some of the work rolls are adjustable to enable the stresses applied by the work rolls to the strip material being processed to be varied across the width of the strip material. In this manner, one or more selected longitudinal regions or zones (e.g., outer edges, mid-edges, a center portion, etc.) of the strip material can be permanently stretched to achieve a desired finished material condition (e.g., flatness).

To achieve a desired material condition, the settings of the adjustable work rolls are usually initially selected based on the type and thickness of the material to be conditioned. For example, a control unit coupled to the leveler may enable an operator to enter the material type and thickness. Based on the material type and thickness information entered by the operator, the control unit may retrieve appropriate default work roll settings. The operator may then vary the default work roll settings prior to conditioning the material and/or during the conditioning process to achieve a desired finished material condition. For example, an operator at an inspection point near the output of the leveler may visually detect an undesirable material condition such as a crossbow condition, a coil set condition, a buckle or wave along one or both of the outer edges, mid-edges, the center, or any other longitudinal region or zone of the strip material being processed, etc. Unfortunately, manually configuring or adjusting a leveler in this manner to condition strip material to achieve a desired condition can be a time consuming and error prone process, particularly due to the high degree of human expertise and involvement required.

Using a leveler to process strip material may additionally or alternatively involve a certification process. For example, quantities of cut sheets of the strip material processed by a leveler may be bundled for shipment. A plurality of sheets may be sampled from each bundle and the sampled sheets may be visually inspected and manually measured by an operator. The visual inspection and quantitative measurements may be used to generate, for example, flatness information for the sampled sheets. In turn, the flatness information for the sampled sheets selected from each bundle may be used as statistical information for purposes of certifying the bundles from which the sheets were selected. However, as is the case with known leveler adjustment apparatus and methods, known certification processes are very time consuming and prone to error due to the high degree of human expertise and involvement required.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. **1** illustrates an example of a strip material being pulled from a coiled quantity of the strip material.

FIG. **2** illustrates example areas of compression and tension on a section of strip material passing over a work roll.

FIG. **3** generally illustrates the relationship between work roll diameter and the relative sizes of the compression and tension areas imparted by a work roll on a strip material.

FIG. **4** illustrates the effect of strip material tension on plastic deformation of a strip material.

FIG. **5** illustrates the manner in which decreasing the horizontal center distance between work rolls for a given work roll plunge increases the tensile stress imparted to a strip material.

FIG. **6** illustrates the manner in which increasing the plunge for a given horizontal work roll center distance increases tensile stress imparted to the strip material.

FIG. **7** generally illustrates that portions of a strip material associated with relatively wavy and/or buckled areas are longer than portions of the strip material associated with relatively flat areas.

FIG. **8** generally illustrates an example manner in which backup bearings may be used to support work rolls.

FIG. **9** illustrates an example manner in which work rolls may be set to flatten a strip material having a buckled region or zone.

FIG. **10** is a block diagram of an example system for automatically monitoring and conditioning strip material.

FIG. **11** is a more detailed diagrammatic view of an example manner in which the example system shown in FIG. **10** may be implemented.

FIG. **12** is a block diagram of an example processor-based system that maybe used to implement one or both of the example conditioner control unit and the material monitoring and conditioning feedback unit shown in FIGS. **10** and **11**.

FIG. **13** is flow diagram generally depicting an example manner in which the example material monitoring and conditioning feedback unit of FIGS. **10** and **11** may be configured.

FIG. **14** is a more detailed flow diagram depicting one manner in which the monitor/condition method of FIG. **13** may be implemented.

FIG. **15** is a more detailed flow diagram depicting one manner in which the read sensors method of FIG. **14** may be implemented.

FIG. **16** is a more detailed flow diagram depicting one manner in which the calculate deviations method of FIG. **14** may be implemented.

FIGS. **17** and **18** are a more detailed flow diagram depicting one manner in which the determine zone changes method of FIG. **14** may be implemented.

FIGS. **19**–**25** are more detailed flow diagrams depicting an example manner in which the adjust conditioner method of FIG. **14** may be implemented.

DETAILED DESCRIPTION

In general, the example system described herein receives encoder signals and distance sensor data in order to automatically monitor and/or condition strip material. If an undesirable material condition (e.g., crossbow, coil set, buckles or waves in one or more regions or zones of the strip material, etc.) is detected, one or more work rolls in a material conditioner (e.g., a leveler) may be adjusted to achieve a desired material condition (e.g., flatness). Alternatively or additionally, the example system described herein may automatically produce certification information for predetermined quantities (e.g., individual bundles of sheets) of the strip material.

FIG. **1** illustrates an example of a strip material **100** being pulled from a coiled quantity **102** of the strip material. The strip material may be a metallic substance such as, for example, steel or aluminum, or may be any other desired material. As the strip material **100** is removed from the coiled quantity **102**, it assumes an uncoiled condition or state **104**. Coiled strip material frequently manifests undesirable material conditions that are the result of longitudinal stretching of the strip material during coiling and as a result of remaining in a coiled condition for a period of time. In particular, the coil winding process is usually performed under high tension, which may cause a condition commonly referred to as coil set. If significant, coil set may also manifest itself as a condition commonly referred to as crossbow. Both of these undesirable conditions are manifest in the uncoiled condition or state **104**.

In addition, during a cold mill reduction process, rolling mill conditions and settings may manifest themselves as imperfections in the finished coil. These imperfections appear as waves when they occur near the peripheral zones or regions (e.g., the outer edges) of the strip material **100** and as buckles when they occur near the central zone or region (e.g., the center) of the strip material **100**. In a case where the uncoiled condition or state **104** exhibits coil set, the stretching that has occurred is typically uniform across the width of the strip material **100**. For example, with over-wound coils, the outer surface is uniformly stretched slightly more than the inner surface. Thus, the uncoiled portion **104** of the strip material **100** usually curves toward the inside wrap. As the uncoiled portion **104** is pulled straight, the longer upper surface will cause the shorter inner surface to curl slightly inward (i.e., crossbow).

Undesirable material conditions such as coil set and crossbow can be substantially eliminated using leveling or flattening techniques. Leveling or flattening techniques are based on the predictable manner in which the strip material **100** reacts to stress (i.e., the amount of load or force applied to a material). The structure and characteristics of a strip material change as the load and, thus, stress is increased. For example, with most metals, as the load or force increases from zero the metal supporting the load bends or stretches in an elastic manner. When the load or force applied remains within the elastic load region of the metal and is removed, the metal returns to its original shape. In such an instance, the metal has been flexed, but has not been bent.

At some point, an increase in the load or stress applied to the strip material causes the strip material to change properties so that it is no longer able to return to its original shape. When it is in this condition, the strip material is in a plastic load region. In the plastic load region, small increases in the force or load applied to the strip material cause relatively large amounts of stretching (i.e., deformation) to occur. Further, when a metallic strip material is in plastic state or condition, the amount of stretch that results is time dependent. In particular, the longer the metal is held under a given load (when plastic) the greater the amount of deformation (i.e., permanent stretch).

The amount off force required to cause a metal to change from an elastic condition to a plastic condition is commonly known as yield strength. With a specific formulation of a particular metal, the yield strength is always the same. The higher the yield strength, the stronger the metal. Because leveling or flattening requires a portion of the metal to become plastic, yield strength is as important as thickness when determining appropriate work roll geometries and settings.

Factors such as the percent of elongation cause various metals to react differently to increased load. For example, aluminum will generally stretch much more (i.e., is more elastic) than steel, even if the aluminum and steel have the same yield strength. As a result, most aluminum, in comparison to steel, requires deeper work roll plunge (discussed in detail below) to achieve the same result. In other words, aluminum has to be stretched to a greater degree even though it has the same yield strength as steel. These differences in elasticity can be so significant that many metals such as aluminum appear to require more work than higher strength steels because of the deeper work roll plunge required to achieve a desired material condition.

Conditioning a strip material depends strongly on the reaction the strip material **100** has to being bent around a work roll. FIG. **2** illustrates example areas of compression and tension on a section of the strip material **100** passing over a work roll **200**. When wrapped around the work roll **200**, compressive stresses occur in the portion of the strip material **100** closest to the work roll **200** and tensile stresses occur in the portion of the strip material **100** farthest away from the surface of the work roll **200**. When the strip material **100** is pulled flat, the center is the neutral axis **202**, which is neither in compression nor tension.

Although a strip material such as a metal is typically a homogenous substance, the conditioning concepts described herein may be easier to understand if the stresses are described as occurring in layers. As shown in FIG. **2**, the greatest tension is in the outermost layers of the strip material **100**. Unless sufficient tension is imparted to the strip material **100**, the stresses will result in only elastic strain, and the strip material **100** will return to its original shape after passing over the work roll **200**. However, if sufficient tension is imparted to the strip material **100**, the outer surface layers are subject to sufficient stress to reach the yield strength of the strip material **100**. The surface layers stretch enough to become plastic and, when the tension is removed, retain a new shape. The plastic deformation is greatest at the surface of the strip material **100** farthest from the work roll **200**. The tension imparted to the strip material varies across its thickness and, in particular, diminishes toward the neutral axis **202**. For the layers of the strip material **100** that are near to or on the neutral axis **202**, the tension is low enough that those layers of the strip material **100** are in an elastic state and, thus, are not deformed as a result of passing over the work roll **200**.

The relationship between the diameter of the work roll **200** and thickness of the strip material **100** is a significant factor in the ability of a conditioner (e.g., a leveler) to condition the strip material **100** in a desired manner. For example, if the diameter of the work roll **200** is too large, the resulting stresses produce only elastic strains. In such an instance, after the strip material **100** passes over the work roll **200**, the strip material **100** returns to its original shape.

FIG. **3** generally illustrates the relationship between work roll diameter and the relative sizes of the compression and tension areas imparted by a work roll on the strip material **100**. In general, as the diameter of a work roll decreases, the ratio of the tension surface area (i.e., the surface area of the strip material **100** farthest from the work roll) to the compression surface area (i.e., the surface area of the strip material **100** closest to the work roll) increases. Thus, smaller diameter work rolls can impart greater stresses to the strip material **100** at any given wrap angle.

The practical limits to the reduction of the workroll diameter are mechanical. At some point, the work rolls **200** became too small to transmit the torque required to work the strip material **100**. Another consideration is the ability of the workroll **200** to span the gap between backup bearings without significant deflection. Because of these and other mechanical limitations, material conditioners (e.g., levelers) are typically designed to have a variety of work roll diameters. For any given work roll diameter, the thinnest material that can be effectively worked is limited by the relationship of the workroll diameter to the strip material thickness and the resulting ability to create tension on the outer surface of the strip material **100** by wrapping the strip material **100** around that diameter. The thickest strip material **100** is limited by the mechanical strength constraints of the work rolls **200**, backup bearings (discussed in detail below), drive train and the force the frame and adjustment system can apply to the strip material **100**.

A leveler (i.e., a particular type of material conditioner) typically nests a series of work rolls **200** resulting in a material path that wraps above and below alternating work rolls **200**. Without strip tension, the strip material **100** would bridle around the work rolls **200** (as shown in FIG. **4**) with the neutral axis **202** at its center dividing areas of minimal compression and minimal tension. As tension is increased, the neutral axis **202** moves from the center of the strip material **100** toward the surface of the work roll **200**, thereby significantly increasing the area of tensile stress causing greater plastic deformation of the strip material **100**.

Three things happen as a result of having multiple work rolls **200** in a leveler. First, multiple work rolls **200** allows for multiple passes. This results in more opportunity to yield the strip material **100**. Second, by alternately passing the strip material **100** over and under the work rolls **200**, the stresses are equalized at the upper and lower surfaces of the strip material **100**. This facilitates production of a flat strip material **100** that is relatively free of pockets of distortion. Third, alternating work rolls **200** allows strip tension to be controlled. The surface friction of the bridle path creates strip tension. The control and selective application of that tension allows the strip material **100** to be stretched as it passes through the leveler. By careful control of the path length, the strip material **100** can be selectively stretched, producing desired changes in the shape or condition of the strip material **100**.

FIG. **5** illustrates the manner in which decreasing a horizontal center distance **502** between work rolls for a given work roll plunge (i.e., the vertical center separation or distance) increases the tensile stress imparted to the strip material **100**. In general, for any given work roll plunge, a decreased horizontal center distance **502** increases the tensile stress imparted to the strip material **100** and, thus, the potential for plastic deformation which, when properly controlled, improves the ability to condition the strip material **100**.

FIG. **6** illustrates the manner in which increasing the plunge (i.e., decreasing a vertical center distance **602** between work rolls) for a given work roll horizontal center distance increases tensile stress imparted to the strip material **100**. Typically, an operator and/or a control system (discussed in detail below) controls the strip tension through the selective application of the work roll plunge **602**. As illustrated in FIG. **6**, for a given horizontal center distance, an increased plunge **602** (i.e., a smaller vertical center distance) increases tensile stress in the strip material **100** and, thus, increases the potential for plastic deformation.

In a flattener, which is another type of material conditioner, the centers of all of the work rolls **200** are typically held parallel at all times. The upper work rolls **200** are plunged into the lower work rolls **200** to cause a wave-like bridle effect as the strip material **100** passes through the flattener. The shorter surface of the strip material **100** is stretched slightly down its length and uniformly across its width. Most of the work is done in the first few workroll clusters with feathering to a flat finish occurring throughout the rest of the flattener.

Flattener work rolls **200** are normally mounted in journal end bearings. Occasionally, non-adjustable center support backup bearings are added to minimize deflection of the center of the work rolls **200**. The work rolls **200** used in a flattener are typically large in diameter and have widely spaced centers. Flatteners are typically used to remove undesirable strip material conditions such as coil set and crossbow. However, flatteners are not equipped with adjustable backup bearings to provide differential leveling or conditioning, which is needed to eliminate other types of material conditions, including waves and buckles that may occur along one or more longitudinal regions or zones of a strip material. On the other hand, a leveler (a type material conditioner described above) may be used to perform such differential conditioning, as well as the simple flattening operations that are performed by flatteners.

The cold reduction process may produce metallic strip material that has a non-uniform thickness across its width. If the strip material **100** having such a non-uniform thickness across its width were pulled from a coil and slit into many parallel strands down its length and flattened, the strips from the wavy or buckled areas of the strip material **100** would be longer than the strips from the flat areas of the strip material **100**. FIG. **7** illustrates this by aligning one end of the strips. A material conditioner (e.g., a leveler) may be used to stretch the short lengths to approximately match the long lengths of the strip material **100**, thereby substantially flattening the strip material **100**. If the non-uniform thickness is the result of deflection or crown in the cold reduction rolls, the relatively thin areas of the strip material **100** will be longer (down the length of the coil) than the thick areas of the strip material **100**. These thin areas result in a wave **702** if, near the edge of the strip material **100**, or a buckle **704** (or multiple buckles) if captured in the center of the strip material **100**.

Unlike a flattener, all of the work roll centers of a leveler are not intended to be held parallel. The work rolls **200** of a leveler typically have a relatively small diameter to provide a high tension surface to compression surface ratio. The small diameter of leveler work rolls **200** in a leveler also allows the work rolls **200** to flex under load. Typically, the centers of the top work rolls **200** of a leveler are held in a co-axial relationship, but the centers of the bottom work rolls **200** of the leveler are not necessarily held in such a co-axial relationship.

FIG. **8** generally illustrates an example manner in which backup bearings **800** may be used to support the work rolls **200**. In some material conditioners, such as a leveler, the work rolls **200** are small in diameter and must be backed up along their length to prevent unwanted deflection. As depicted in FIG. **8**, top work rolls **200** are typically backed up rigidly with non-adjustable flights of bearings **800***a*. Bottom work rolls **200** may be supported with a series of adjustable backup bearings **800***b* mounted below the work rolls **200** and set on the same spacings as the upper backup bearings **800***a*. By adjusting the bottom backup bearings **800***b* differently across the width of the work rolls **200**, differential conditioning across the width of the strip material **100** may be achieved. Each numbered position in FIG. **8** corresponds to a flight of backup bearings.

As discussed above, the strip material **100** having the center buckle **704** is longer in the center of the strip material **100** than on the edges of the strip material **100**. If the outermost flights of the backup bearings **800** are set to have more plunge **602** (i.e., a smaller vertical work roll center distance or separation) than the center flights of backup bearings **800**, the strip material **100** will follow a longer path at its edge than at its center (see FIG. **9**). The strip material **100** may be stretched if tensile stress exceeding the yield strength of the strip material **100** is imparted to the strip material **100** (i.e., plastic deformation). If the path is longer at the edges (i.e., the peripheral regions or zones) of the strip material **100**, the leveler will stretch or lengthen the peripheral regions or zones (i.e., the outermost edges) of the strip material. In this manner, the leveler may be used to stretch the peripheral regions or zone of the strip material **100** to a length that approximately matches the length of the central longitudinal region or zone of the strip material **100**. When this is done, the coil set is removed, and the strip material **100** will be conditioned to be substantially flat. Of course, the backup bearings **800** may be set in different manners to achieve any other desired material condition (i.e., other than substantial flatness).

FIG. **10** is a block diagram of an example system **1000** for automatically monitoring and conditioning the strip material **100**. As set forth in greater detail below, the example system **1000** may be used to condition strip material pulled from, for example, a coil of the strip material, to achieve a desired material condition. For example, the example system **1000** may be used to substantially flatten or level the strip material **100**, thereby substantially eliminating material conditions such as, for example, coil set, crossbow, waves and/or buckles extending along one or more longitudinal regions or zones (e.g., outer edges, mid-edges, etc.) of the strip material **100**. Alternatively or additionally, the example system **1000** may be used to achieve any other desired non-flat material condition. More specifically, the example system **1000** uses a plurality of sensors to develop topographic data representing the deviations of the surface of the strip material **100** from a desired condition (e.g., a flat condition). The topographic data is developed across the width and along the length of the strip material **100**. The topographic data may then be used to automatically adjust settings on a material conditioner to achieve the desired material condition. Additionally or alternatively, the topographic data may be used to develop certification information related to one or more material conditions (e.g., flatness) for predetermined quantities of the strip material (e.g., a sheet, a bundle of sheets, etc.) of the strip material **100**.

Now turning in detail to FIG. **10**, the example system **1000** includes a material conditioner **1002**. For the example system **1000** described herein, the material conditioner **1002** is described as being a leveler, which is a well known type of material conditioner. However, those of ordinary skill in the art will readily appreciate that other types of material conditioners could be used instead. For example, the apparatus and methods described herein could be advantageously applied to a flattener or to other types of rollforming equipment.

As shown in FIG. **10**, the material conditioner **1002** may include work rolls **1004** that are supported by backup bearings **1006**. Some of the backup bearings **1006** may be non-adjustable or relatively fixed in place, thereby fixing the ones of the work rolls **1004** supported by those non-adjustable ones of the backup bearings **1006** in place. Other ones of the backup bearings **1006** may be adjustable, thereby enabling the ones of the work rolls **1004** supported by the adjustable ones of the backup bearings **1006** to be adjusted or moved relative to the fixed ones of the work rolls **1004**. Adjustment of the movable ones of the work rolls **1004** may enable substantially continuous or stepwise variation of the plunge of the work rolls **1004**, thereby enabling a substantially continuous or stepwise variation of the stress imparted to the strip material **100**. Preferably, but not necessarily, the movable or adjustable ones of the backup bearings **1006** are arranged in independently movable or adjustable flights. In this manner, the plunge and, thus, the stress imparted to the strip material **100** can be varied across the width of the strip material **100**. Varying the stresses applied to the strip material **100** across its width, enables the performance of the material conditioning operations described in greater detail below in which the stresses applied to the material may be varied as needed within different longitudinal regions or zones of the strip material and over time to achieve a desired material condition.

The backup bearings **1006** may be actuated using hydraulics **1008** and the position or location (e.g., the plunge) of the backup bearings **1006** may be sensed by transducers **1010**. The transducers **1010** may include linear voltage displacement transformers (LVDTs) or any other suitable position sensing device or combination of devices. A conditioner control unit **1012** is communicatively coupled to the hydraulics **1008** and the transducers **1010**. The conditioner control unit **1012** receives the backup bearing position or location information from the transducers **1010** and sends commands or other signals to the hydraulics **1008** to cause the adjustable ones of the backup bearings **1006** to be moved to a desired location, position, plunge setting, etc.

As the strip material **100** is processed by the material conditioner **1002**, the sensors **1014** detect changes in the condition (e.g., deviations from the flat condition) of the strip material **100**, both across its width and along its length as the strip material **100** moves through the material conditioner **1002**. As described in greater detail below in connection with FIG. **11**, the sensors **1014** may include a plurality of distance sensors spaced across the width of the strip material **100** such that each of the distance sensors corresponds to a particular longitudinal region or zone of the strip material **100**. For example, the regions or zones may be peripheral or outer edges, mid-edges, a center portion, etc. of the strip material **100**.

The sensors **1014** may also include one or more length or travel sensors that provide information related to the amount or length of the strip material **100** that has passed through the work rolls **1004**. In this manner, the deviation information collected by the sensors **1014** can be associated with locations along the length of the strip material **100**, thereby enabling generation of topographical data related to the condition of the strip material **100**.

The sensors **1014** are communicatively coupled to a material monitoring and conditioning feedback (MMCF) unit **1016** that processes signals or information received from the sensors **1014** such as, for example, material condition deviation information and length information (e.g., the amount of the strip material **100** that has passed through the work rolls **1004**) to generate topographical data associated with one or more conditions of the strip material **100**. The MMCF unit **1016** may then use the topographical data to generate corrective feedback information that is conveyed via a communication link **1018** to the conditioner control unit **1012**. The conditioner control unit **1012** may use the corrective feedback information to make adjustments to the work rolls **1004** via movements of the hydraulics **1008** and the backup bearings **1006** to achieve a desired material condition for the strip material **100**. For example, the MMCF unit **1016** may generate corrective feedback information to achieve a substantially flat condition for the strip material **100**.

Alternatively or additionally, the MMCF unit **1016** may generate certification information such as, for example, flatness information for predetermined quantities of the strip material **100**. For example, the MMCF unit **1016** may use the topographical information or data to generate flatness data for each cut sheet of the strip material **100** and, for each bundle of sheets, may generate certification information to be associated with the bundles by, for example, applying a label containing the certification information to each of the bundles.

The communication link **1018** may be based on any desired hardwired media, wireless media, or any combination thereof. In addition, any suitable communication scheme or protocol may be used with the link **1018**. For example, the link **1018** may be implemented using an Ethernet-based platform, telephone lines, the Internet, or any other platform using any desired communication lines, network and/or protocol.

Although the example system **1000** depicts the conditioner control unit **1012** and the MMCF unit **1016** as being separate units that are communicatively coupled via the link **1018**, the functions performed by the units **1012** and **1016** could be combined into a single device if desired. However, in some cases separation of the functions performed by the units **1012** and **1016** may be advantageous. For example, a separate MMCF unit **1016** may be easily retrofit to existing material conditioners and conditioner control units, thereby enabling expensive equipment having substantial useful life to realize the advantages of the apparatus and methods described herein.

FIG. **11** is a more detailed diagrammatic view of an example manner in which the example system **1000** shown in FIG. **10** may be implemented. As depicted in FIG. **11**, the strip material **100** passes through the work rolls **1004**, one of which is depicted as being fixed and the other of which is depicted as being adjustable. For purposes of clarity, only two work rolls are shown. However, more than two work rolls may be used if desired. A plurality of distance sensors **1102**, **1104**, **1106** and **1108** detect the distance to a surface of the strip material **100**. The distance sensors **1102**–**1108** may be implemented using any desired contact and/or non-contact sensor technology or combination of technologies, including capacitive sensors, ultrasonic sensors, laser-based or other optical devices, riding needle sensors, etc.

Regardless of the particular technologies employed by the distance sensors **1102**–**1108**, the sensors **1102**–**1108** may be calibrated to a predetermined fixed distance using, for example, a known substantially flat surface. Such an absolute calibration enables the distance sensors **1102**–**1108** to detect material conditions (e.g., crossbow, buckles, waves, etc.) that are evidenced as deviations from a known flat condition across the width and along the length of the strip material **100**.

The example implementation of the system **1000** shown in FIG. **11** depicts five distance sensors (i.e., the sensors **1102**–**1108**) that, starting from the outer edges of the strip material **100**, are spaced substantially equally across the width of the strip material **100**. However, a different number of distance sensors and different spacing between such distance sensors may be used if desired. Further, it should be understood that while the methods described below in connection with FIGS. **17**–**25** are based on the MMCF unit **1016** receiving distance or deviation information from five sensors corresponding to five longitudinal regions or zones along the strip material **100**, more or fewer sensors and zones or regions may be used instead.

Still further, it should be recognized that there is not necessarily a one-to-one correspondence between the regions or zones associated with the distance sensors **1102**–**1108** and the adjustment zones or regions across the adjustable ones of the work rolls **100**. For example, the material conditioner **1002** (FIG. **10**) may have more or fewer sets of adjustable ones of the backup bearings **1006** (FIG. **10**) than sensor zones. Thus, the MMCF unit **1016** may map the distance sensors **1102**–**1108** to adjustable ones of the backup bearings **1006** (FIG. **10**) so that each of the five regions or zones defined by the distance sensors **1102**–**1108** corresponds to at least one adjustable set of the backup bearings **1006** (FIG. **10**). In this manner, sensor zones are mapped to material conditioner control zones or regions. For example, a first adjustable flight of the backup bearings **1006** may correspond to a first sensor zone along an outer edge of the material (e.g., the zone associated with the distance sensor **1102**), a second adjustable flight of the backup bearings **1006** may correspond to a second sensor zone along a first mid-edge of the strip material (e.g., the zone associated with the distance sensor **1104**), a third adjustable flight of the backup bearings **1006** may correspond to a third sensor zone along a center portion of the strip material **100** (e.g., the zone associated with the distance sensor **1106**), and so on. On the other hand, multiples flights of adjustable ones of the backup bearings **1006** may correspond to each of the sensor zones or regions.

Preferably, but not necessarily, the distance sensors **1102**–**1108** are spaced equally across the width of the strip material **100**. However because the width of the strip material **100** processed by the system **1000** may vary over different production runs, the distance sensors **1102**–**1108** may be moved accordingly and, thus, will not always correspond to the same one or more material conditioner control zones (i.e., adjustable flights of the backup bearings **1006**).

As is also depicted in FIG. **11**, the example system **1000** includes an encoder **1110** for the purpose of measuring an amount or length of the strip material **100** that has moved through the work rolls **1004**. For example, the encoder **1110** may be implemented using a twelve inch encoder wheel that rides on the strip material **100** as the strip material **100** moves. In that case, each time the wheel of the encoder **1110** makes a complete revolution, the strip material **100** has traveled twelve inches. The encoder **1110** may be radially divided into a plurality of signal points. For example, if a twelve inch encoder is divided into twelve signal points, the encoder **1110** would produce a signal every time the strip material **100** travels one inch. In practice, the encoder **1110** may be divided into any number of signal points (e.g., 1200 per revolution).

Thus, by spacing the sensors **1102**–**1108** across the strip material **100** and periodically taking distance measurements (i.e., at a predetermined time interval) as the strip material **100** is moved through the conditioner **1002**, the MMCF **1016** can acquire data indicative of the overall topography of the strip material **100**. However, the strip material **100** may be moved through the conditioner **1002** at different rates of speed. As a result, the time between readings of the distance sensors **1102**–**1108** may not be an accurate indication of distances traveled down the strip material **100**. Thus, the length or distance traveled information can be supplied by the encoder **1110** to eliminate the inaccuracies that could otherwise result if the measurement interval time were used to estimate the strip material length between readings of the distance sensors **1102**–**1108**.

FIG. **12** is a block diagram of an example processor-based system **1200** that maybe used to implement one or both of the example leveler control unit **1012** and the MMCF unit **1016** shown in FIGS. **10** and **11**. The example system **1200** may be based on a personal computer (PC) or any other computing device. The example system **1200** illustrated includes a main processing unit **1202** powered by a power supply **1204**. The main processing unit **1202** may include a processor **1206** electrically coupled by a system interconnect **1208** to a main memory device **1210**, a flash memory device **1212**, and one or more interface circuits **1214**. In one example, the system interconnect **1208** is an address/data bus. Of course, a person of ordinary skill in the art will readily appreciate that interconnects other than busses may be used to connect the processor **1206** to the other devices **1210-1214**. For example, one or more dedicated lines and/or a crossbar may be used to connect the processor **1206** to the other devices **1210-1214**.

The processor **1206** may be any type of well known processor, such as a processor from the Intel Pentium® family of microprocessors, the Intel Itanium® family of microprocessors, the Intel Centrino® family of microprocessors, and/or the Intel XScale® family of microprocessors. In addition, the processor **1206** may include any type of well known cache memory, such as static random access memory (SRAM). The main memory device **1210** may include dynamic random access memory (DRAM) and/or any other form of random access memory. For example, the main memory device **1210** may include double data rate random access memory (DDRAM). The main memory device **1210** may also include non-volatile memory. In an example, the main memory device **1210** stores a software program which is executed by the processor **1206** in a well known manner. The flash memory device **1212** may be any type of flash memory device. The flash memory device **1212** may store firmware and/or any other data and/or instructions.

The interface circuit(s) **1214** may be implemented using any type of well known interface standard, such as an Ethernet interface and/or a Universal Serial Bus (USB) interface. One or more input devices **1216** may be connected to the interface circuits **1214** for entering data and commands into the main processing unit **1202**. For example, an input device **1216** may be a keyboard, mouse, touch screen, track pad, track ball, isopoint, and/or a voice recognition system.

One or more displays, printers, speakers, and/or other output devices **1218** may also be connected to the main processing unit **1202** via one or more of the interface circuits **1214**. The display **1218** may be a cathode ray tube (CRT), a liquid crystal displays (LCD), or any other type of display. The display **1218** may generate visual indications of data generated during operation of the main processing unit **1202**. The visual indications may include prompts for human operator input, calculated values, detected data, etc.

The example system **1200** may also include one or more storage devices **1220**. For example, the example system **1200** may include one or more hard drives, a compact disk (CD) drive, a digital versatile disk drive (DVD), and/or other computer media input/output (I/O) devices.

The example system **1200** may also exchange data with other devices **1222** via a connection to a network **1224**. The network connection may be any type of network connection, such as an Ethernet connection, digital subscriber line (DSL), telephone line, coaxial cable, etc. The network **1224** may be any type of network, such as the Internet, a telephone network, a cable network, and/or a wireless network. The network devices **1222** may be any type of network devices. For example, the network device **1222** may be a client, a server, a hard drive, etc., including another system similar or identical to the example system **1200**. More specifically, in a case where the MMCF unit **1016** and the conditioner control unit **1012** are implemented as separate devices coupled via the link **1018**, one of the units **1012** and **1016** may correspond to the example system **1200**, the other one of the units **1012** and **1016** corresponds to the network device **1222** (which may also be implemented using a system similar or identical to the system **1200**), and the link **1018** corresponds to the network **1224**.

FIGS. **13**–**25** described in detail below an example manner in which the example system **1000** of FIG. **10** may be configured to produce certification data or information for the strip material **100** and/or to adjust a material conditioner (e.g., the example material conditioner **1002** of FIG. **10**) to achieve a desired material condition (e.g., a substantially flat condition) for the strip material **100**. Preferably, the methods depicted in FIGS. **13**–**25** are embodied in one or more software programs or instructions that are stored in one or more memories and executed by one or more processors (e.g., processor **1206** of FIG. **12**) in a well known manner. However, some or all of the blocks shown in FIGS. **13**–**25** may be performed manually and/or by another device. Additionally, although the methods depicted in FIGS. **13**–**25** are described with reference to a number of example flow diagrams, a person of ordinary skill in the art will readily appreciate that many other methods of performing the methods described therein may be used. For example, the order of many of the blocks may be altered, the operation of one or more blocks may be changed, blocks may be combined, and/or blocks may be eliminated.

Now turning in detail to FIG. **13**, a flow diagram generally depicts an example manner in which the example system **1000** of FIG. **10** may be configured. Initially, the system **1000** (FIG. **10**) determines if strip material is present in the material conditioner **1002** (block **1300**). The presence of the strip material **100** may be detected using the sensors **1014** (e.g., the distance sensors **1102**–**1108** and/or the encoder **1110** shown in FIG. **11**) or may be detected in some other manner via the conditioner control unit **1012**. If the presence of the strip material **100** is not detected, the system **1000** remains at block **1300**.

On the other hand, if the system **1000** detects the presence of the strip material **100** at block **1300**, the system **1000** resets data buffers containing, for example, data that may have been previously obtained from the sensors **1014** and/or random data that may be present in the data buffers following a power-up operation or the like (block **1302**). The data buffers may be located within the MMCF unit **1016** and, in particular, in the case where the MMCF unit **1016** is implemented using a processor-based system such as the example processor-based system **1200** shown in FIG. **12**, the data buffers may be implemented within one or more of the flash memory **1212**, the main memory **1210** and/or the processor **1206**.

Following the reset of the data buffers at block **1302**, the system **1000** may then determine if the material conditioner **1002** is operational or running (block **1304**). Such a determination may be made using, for example, the sensors **1014**. In particular, time-based variations in readings (e.g., time-varying distance, deviation and or length values or signals) would normally indicate that the strip material **100** is moving through the material conditioner **1002**. In particular, time-variant information supplied by the encoder **1110** (FIG. **11**) and/or the distance sensors **1102**–**1108** (FIG. **11**) would be indicative of movement of the strip material **100** through the material conditioner **1002** (FIG. **10**). Of course, other methods of detecting the movement of the strip material through the material conditioner **1002** could be used instead.

If the material conditioner **1002** is not operational or running at block **1304**, the system **1000** stops adjusting the settings of the material conditioner **1002** and/or waits (block **1306**). On the other hand, if the material conditioner **1002** is operational or running at block **1304**, control is passed to block **1308**. At block **1308** the system **1000** initializes the settings associated with the conditioner control unit **1012** and the material conditioner **1002**. Such an initialization may involve receiving information associated with the strip material **100** such as, for example, material type information, material thickness information, etc. An operator may enter such material information via, for example, one or more of the input devices **1216** (FIG. **12**), which may be communicatively coupled to one or both of the MMCF unit **1016** and the conditioner control unit **1012**. The material information may, in turn, be used to select appropriate default settings (e.g., work roll plunge, adjustable work roll profile and/or backup bearing height settings, etc.) for the material conditioner **1002**. Such default settings may be stored in one or both of the MMCF unit **1016** and the conditioner control unit **1012**.

Once the conditioner settings have been initialized at block **1308**, the system **1000** may then monitor the condition of the strip material **100** for purpose of generating certification data and/or for purpose of adjusting the material conditioner **1002** to achieve a desired material condition (e.g., a substantially flat condition) (block **1310**). At the conclusion of the monitor/condition process (block **1310**), control is returned to block **1312**, at which the monitored information (e.g., the data buffers, displayed data, etc.) may be cleared prior to a cessation of operations.

FIG. **14** is a more detailed flow diagram depicting one manner in which the monitor/condition method (depicted as block **1310** of FIG. **13**) may be implemented. Upon starting the monitor/condition method (block **1310**), the system **1000** reads the sensors **1014** (block **1400**). In particular, distance or deviation information may be read from the distance sensors **1102**–**1108** (FIG. **11**) at predetermined time intervals so that multiple sets of data are collected from the sensors **1102**–**1108** at block **1400**. Likewise, linear distance or travel length information or data may be received from the encoder **1110** (FIG. **1**) during each time at which distance information or data is collected from the distance sensors **1102**–**1108**. A more detailed description of the manner in which the sensors **1014** may be read at block **1400** is provided in connection with FIG. **15** below.

After the sensor data is read or collected at block **1400**, the system **1000** calculates deviations in the collected data (block **1402**). In particular, the system **1000** may calculate distance value variations within each of the longitudinal zones or regions of the strip material **100** as well as variations between the zones or regions. A more detailed discussion of one manner in which such deviations may be calculated and used to determine other parameters indicative of a material condition is provided below in connection with FIG. **16**.

After the data deviations have been calculated at block **1402**, the system **1000** determines if the zones or regions monitored by the sensors **1014** are substantially equal to a target material condition (block **1404**). In particular, the system **1000** may compare the average deviations of the zones to each other and/or to one or more predetermined threshold values to determine if the individual zones are at the desired target condition. For example, if the desired target condition is a substantially flat condition, then the average deviations for each of the zones may be compared to each other (i.e., to determine the degree of similarity between the zones) and/or the average deviations of all of the zones may be compared to a predetermined threshold indicative of a substantially flat condition.

If the system **1000** determines at block **1404** that the zones or regions are not at the desired target conditions, zone changes are then determined at block **1406**. In general, zone changes are generated by comparing the relative material conditions (e.g., the flatness) of the zones monitored by the sensors **1014** (FIG. **10**). Certain patterns of material conditions are recognized and appropriate adjustment values for use by the material conditioner **1002** are determined based on the patterns. A more detailed description of one manner in which the five distance sensors **1102**–**1108** shown in FIG. **11** may be used to adjust five zones or regions of the strip material **100** to achieve a desired material condition is described below in connection with FIGS. **17** and **18**.

Once the required zone changes have been determined at block **1406**, those changes are then used by, for example, the conditioner control unit **1012** (FIGS. **10** and **11**) to adjust the material conditioner **1002** by, for example, varying the profiles one or more of the work rolls **1004** via the backup bearings **1006** and the hydraulics **1008**. In general, the adjustments to the work rolls **1004** may be made in a step-wise fashion based, at least in part, on the degree to which the zones deviate from the desired condition. A more detailed description of one manner in which adjustments to the settings of the material conditioner **1002** may be made is provided below in connection with FIGS. **19**–**25**.

Following the conditioner adjustments at block **1408**, or if at block **1404** the system **1000** determines that the zones are substantially equal to their target conditions, the system **1000** logs the zone information or data to the buffer (block **1410**). After logging the data in the buffer at block **1410**, the system **1000** determines if a sheet of the strip material **100** is to be cut (block **1412**). A cut sheet determination may be made based on information from the conditioner control unit **1012**. Regardless of where the cut sheet information or signal is generated, if a sheet is cut, the system **1000** (e.g., the MMCF unit **1016**) calculates one or more quality parameters associated with that sheet (block **1414**). In particular, as described in greater detail in connection with FIG. **16**, the quality parameters may include, for example, one or more I-units values for the sheet. I-units are a well-known measure that represents the degree to which a material deviates from a flat condition. Of course, different or additional quality parameters may be calculated at block **1414**.

After calculating the quality parameters at block **1414**, the sheet count is incremented at block **1416**. Following the incrementing of the sheet count at block **1416** or if a cut sheet is not indicated at block **1412**, the system **1000** determines if a sufficient quantity of sheets has been formed to generate a bundle of sheets (block **1418**). If the system **1000** determines that a bundle is to be formed at block **1418**, the system **1000** prints a bundle label, which is affixed or otherwise associated with the bundle, containing certification information for that bundle. Quality parameters associated with the highest quality sheet and the lowest quality sheet within the bundle may be printed on the label. For example, such quality parameters may include the I-units, which are a well known flatness standard, for each of these sheets. One example manner in which the system **1000** may calculate I-units is described in greater detail below in connection with FIG. **16**. After the bundle label is printed, the bundle information including, for example, the quality parameters associated with that bundle (all or some of which may also appear on the bundle label) are logged for possible later retrieval (block **1422**). The quality information and the sheet count information stored in the buffer(s) of the system **1000** may then be reset (e.g., set to zero or some other predetermined value) (block **1424**).

Following the reset of the quality and count values at block **1424** or if the system **1000** determines at block **1418** that a bundle is not being completed, the system **1000** determines if there is a fault (e.g., a mechanical and/or software failure) (block **1425**). If there is no fault at block **1425**, control returns to block **1400**. On the other hand, if there is a fault at block **1425**, then control returns to block **1312** of FIG. **13**.

FIG. **15** is a more detailed flow diagram depicting one manner in which the read sensors method (block **1400**) of FIG. **14** may be implemented. Initially, the system **1000** determines if the data buffer is full (block **1500**). If the data buffer is full, the buffer index is reset to a predetermined value (e.g., zero) (block **1502**). On the other hand, if the data buffer is not full at block **1500**, control is passed to block **1504**.

At block **1504**, the system **1000** (e.g., the MMCF **1016**) reads the zones. In particular, the system **1000** may acquire distance or deviation information from each of the distance sensors **1102**–**1108** (FIG. **11**) and the encoder **1110** (FIG. **11**) over a predetermined number of sampling intervals. For example, each of the distance sensors **1102**–**1108** (FIG. **11**) may be polled or read on a periodic basis (i.e., at fixed time intervals or some other predetermined times) by the MMCF unit **1016** (FIG. **11**). The information received by the MMCF unit **1016** may correspond to the individual distances between the sensors **1102**–**1108** and the upper surface of the strip material **100** underlying the sensors **1102**–**1108**.

Preferably, but not necessarily, the sensors **1102**–**1108** are calibrated so that the surface of the material conditioner **1002** opposite the sensors **1102**–**1108** and across which the strip material **100** moves through the material conditioner **1002** (e.g., the tops of the work rolls **1004**) is equal to a zero distance or other predetermined distance value. In this manner, any deviation of the material condition of the strip material **100** (e.g., waves, buckles, crossbow, etc.) may be detected as positive (i.e., greater than zero) distance variations across zones (e.g., crossbow) and/or distance variations along one or more of the longitudinal regions or zones of the strip material **100** (e.g., a wave along an edge).

In each instance that zone distance information is read from the sensors **1102**–**1108** (FIG. **11**), length information is read from the encoder **1110** (FIG. **11**) and is associated with the distance information. Thus, the zone information (e.g., distance information and length information) may be envisioned as a data table in which each column of the table uniquely corresponds to one of the sensors **1102**–**1108** and the encoder **1110**, and each of the rows represents a sampling event or time. The number of sampling events or times (e.g., rows of data) may be selected to suit the particular needs of a given material monitoring and/or conditioning application. For example, in some applications more than a thousand sampling events may take place at block **1504**. However, other applications may require more or fewer sampling events.

After the zone data has been read at block **1504**, the system **100** (e.g., the MMCF unit **1016**) determines the minimum and maximum deviation or distance readings within each zone (block **1506**). At block **1508**, the system **1000** determines the total length of the strip material **100** that has passed through the conditioner **1002** during the collection of zone data at block **1504**. For example, the MMCF unit **1016** (FIG. **11**) may determine the change in the count values or other signals received from the encoder **1110** (FIG. **11**) and may convert that count value into a length value. For example, in the case where the encoder **1110** is a twelve inch encoder (i.e., has a twelve inch circumference) and outputs a signal or increments its count once per inch traveled, a count change of one hundred indicates that one hundred inches of the strip material **100** have passed through the material conditioner **1002** during the zone readings taken at block **1504**. After the length has been determined at block **1508**, the system **1000** increments the buffer index (block **1510**).

FIG. **16** is a more detailed flow diagram depicting one manner in which the calculate deviations method (block **1402**) of FIG. **14** may be implemented. Initially, the system **1000** (FIG. **10**) determines if the buffer is full (block **1600**). If the buffer is not full at block **1600**, then the system **1000** increments the buffer index (block **1602**) and control is passed to block **1404** of FIG. **14**. On the other hand, if the buffer is full at block **1600**, then control is passed to block **1604**.

At block **1604**, the system **1000** (e.g., the MMCF unit **1016**) determines the average of the deviation or distance values currently stored in the buffer. In the case where the MMCF unit **1016** obtains the deviation or distance information from the distance sensors **1102**–**1108** and the sensors **1102**–**1108** are calibrated so that any measured deviations (i.e., distance changes) are positive (i.e., greater than zero) with respect to a surface of the material conditioner **1002** underlying the strip material **100**, then the zone averages are representative of the degree to which each zone deviates from a flat or other desired condition. In general, larger average values for a given zone are indicative of a greater deviation from a flat condition within that zone. While the examples described herein use zone averages to detect, monitor or measure the deviation of the strip material **100** from a substantially flat condition, different or additional statistical proxies could be used if desired. For example, some fraction of the average values could be used, a maximum deviation value(s) could be used, a square root of a sum of squares of deviations could be used, etc.

Furthermore, it should be recognized that, if calibrated in the above-described manner, the distance readings obtained from the sensors **1102**–**1108** (FIG. **11**) would be offset by an amount equal to the thickness of the strip material **100**. As a result, in a case where the zone averages are all substantially non-zero and equal to each other and offset from zero by an amount substantially equal to the thickness of the strip material **100**, those averages are, indicative of a substantially flat condition. More generally, as described in greater detail below, a substantially flat condition for the strip material corresponds to a condition in which the averages for all of the zones (e.g., all five zones for the example implementation shown in FIG. **11**) are substantially equal.

After the zone averages have been determined at block **1604**, the system **1000** may determine the minimum and maximum average values across all zones (block **1606**). The system **1000** may then determine if the current calculation of deviations is a first pass (i.e., the first time for the strip material **100** being processed by the material conditioner **1002**) (block **1608**). If the system **1000** determines that the current deviation calculations are being made during a first pass at block **1608**, the system **1000** performs a first pass initialization (block **1610**). Such a first pass initialization may include initialization of variables that require initialization following a system power up or the like. If the current deviation calculations are not part of a first pass (block **1608**), then the system **1000** may initialize system variables containing values such as the minimum and maximum deviation or distance readings for each zone, the inverse of the average length between peaks (which is similar to a frequency of the deviations) for each zone, as well as any other variables desired (block **1612**).

The system **1000** may then determine the minimum and maximum distance or deviation readings for each of the zones (block **1614**). For example, in the case where the five sensors **1102**–**1108** (FIG. **11**) and, thus, five zones, are used, the minimum and maximum readings within the buffer for each of the zones are determined. The number of peaks within each of the zones is then calculated (block **1616**). For example, for each zone, peaks may be found by identifying those distance or deviation readings that are preceded and followed by smaller values. Of course, any other desired manner of detecting peak values may be used instead. The length of the strip material **100** corresponding to the zone readings in the buffer is then determined (block **1618**). For example, the length may be calculated by subtracting the maximum and minimum encoder readings (e.g., from the encoder **1110** of FIG. **11**) and converting the encoder readings difference to a length based on the known characteristics of the encoder **1110** (FIG. **11**).

The system **1000** may then calculate the peak value (e.g., the overall wave height) for each of the zones stored in the buffer (block **1620**). For example, the peak value for each zone may be determined by multiplying the average value for the zone by two and subtracting the known thickness of the strip material **100**. Of course, other methods of calculating a peak value for each zone may be used instead. The system **1000** then calculates an intermediate parameter “S” for each of the zones (i.e., the zone data stored in the buffer) as defined in Equation 1 below (block **1622**).

$$S = \text{PeakValue}/\text{Span} \qquad \text{Equation 1}$$

The variable “Peak Value” is the peak value calculated at block **1620** and the variable “Span” is calculated by dividing the length value for each zone (calculated at block **1618**) by the number of peaks counted for each zone (calculated at block **1616**). The S parameter for each zone may then be used to calculate the I-units for each zone using the well-known equation set forth below as Equation 2 (block **1624**). As is well known, the I-units for a zone are indicative of the shape or flatness of a material zone or region. In general, a lower I-units value corresponds to a higher degree of flatness.

$$I\text{-units} = 2.47 * S^2 * 10^5 \qquad \text{Equation 2}$$

After calculating the I-units for each of the zones (i.e., the zone data stored in the buffer), the minimum and maximum I-units for each of the zones are determined (block **1626**) and control returns to block **1404** of FIG. **14**.

FIGS. **17** and **18** are a more detailed flow diagram depicting one manner in which the determine zone changes method (block **1406**) of FIG. **14** may be implemented. In the example method of FIGS. **17** and **18**, five sensing, material condition monitoring and/or adjustment zones are used. In particular, zone **1** corresponds to the distance sensor **1102** (FIG. **11**) and a first outer edge of the strip material **100**. In a similar manner, zones **2**, **3**, **4** and **5** correspond to the distance sensors **1104**, **1106** and **1108**, respectively, and to longitudinal regions of the strip material **100**, including a first mid-edge, a center, a second mid-edge and a second outer edge, respectively. In addition, for purposes of clarity, the material conditioner **1002** (FIG. **10**) is described as having five corresponding adjustment zones (i.e., adjustment zones **1** through **5** that correspond to the five longitudinal regions of the strip material **100** and the sensor zones **1** through **5**. However, it should be recognized, as noted above, that there does not necessarily have to be a one-to-one correspondence between the number and/or location of adjustment zones (e.g., adjustable backup bearings) and the number and/or location of the sensor zones. For example, each sensor zone and/or material zone may be mapped to or may correspond to two or more adjustment zones of the material conditioner **1002** (FIG. **10**).

Continuing with the example zone definitions as set forth above, the system **1000** initially determines if the all of the zones (i.e., zones **1** through **5**) associated with the strip material **100** are substantially flat (block **1708**). Such a flatness determination may be made by, for example, comparing the average deviation and/or the maximum I-units for each of the zones to a predetermined threshold value corresponding to a desired or substantially flat condition. If the system **1000** determines at block **1708** that all of the zones are substantially flat, then control is passed to block **1408** of FIG. **14**.

On the other hand, if the system **1000** determines at block **1708** that all of the zones are not substantially flat (i.e., at least one of the zones is not substantially flat), then the system **1000** determines if zone **1** is substantially flat (block **1710**). If zone **1** is substantially flat, then control is passed to block **1812** of FIG. **18**. At block **1812**, a determination is made whether zone **3** is substantially flat. If zone **3** is not substantially flat, then the system **1000** determines that zone **3** should be adjusted by an amount equal to the average deviation for zone **3** (block **1814**) and control is returned to block **1408** (FIG. **14**). On the other hand, if zone **3** is substantially flat (block **1812**), then the system **1000** determines if zone **4** is flatter (e.g., has smaller I-units value and/or average deviation value) flatter than zone **5** (block **1816**). If zone **4** is not flatter than zone **5** (block **1816**), then the system **1000** determines that zone **4** is to be adjusted by the average deviation of zone **4** (block **1818**) and control is returned to block **1408** (FIG. **14**). If zone **4** is flatter than zone **5** (block **1816**), then the system **1000** determines whether zone **4** is flatter than zone **3** (block **1820**). If zone **4** is not flatter than zone **3** (block **1820**), then the system **1000** determines that zone **5** is to be adjusted by the average deviation of zone **5** (block **1822**) and control returns to block **1408** (FIG. **14**). On the other hand, if zone **4** is flatter than zone **3**, then the system **1000** determines that zone **3** is to be adjusted by the average amount of deviation of zone **3** (block **1824**) and control is returned to block **1408** (FIG. **14**).

If it is determined at block **1710** (FIG. **17**) that zone **1** is not substantially flat, then the system **1000** determines if zone **2** is substantially flat (block **1726**). If zone **2** is substantially flat (block **1726**), then control is passed to block **1828** of FIG. **18**. At block **1828**, the system **1000** determines if zone **5** is substantially flat. If zone **5** is substantially flat at block **1828**, then the system **1000** determines that zone **1** is to be adjusted by an amount equal to the average deviation of zone **1** (block **1830**) and control is returned to block **1408** (FIG. **14**). On the other hand, if zone **5** is not substantially flat at block **1828**, then the system **1000** determines if zone **1** is flatter than zone **5** (block **1832**). If zone **1** is flatter than zone **5** (block **1432**), then the system **1000** determines that zones **1** and **5** are to be adjusted by an amount equal to the average deviation for zone **5** (block **1834**) and control is returned to block **1408** (FIG. **14**). On the other hand, if the system **1000** determines at block **1432** that zone **1** is not flatter than zone **5** (block **1832**), then the system **1000** determines that zones **1** and **2** are to be adjusted by an amount equal to the average deviation for zone **5** (block **1836**) and control is returned to block **1408** (FIG. **14**).

If the system **1000** determines at block **1726** that zone **2** is not substantially flat, then the system **1000** determines if zone **5** is substantially flat (block **1740**). If zone **5** is substantially flat (block **1740**), then the system **1000** determines if zone **1** is flatter than zone **2** (block **1742**). If zone **1** is flatter than zone **2** at block **1742**, then zones **1** and **2** are adjusted by an amount equal to the average deviation of zone **2** (block **1744**). On the other hand, if zone **1** is not flatter than zone **2** at block **1742**, then the system **1000** determines at block **1746** that zones **1** and **3** are to be adjusted by an amount equal to the average deviation of zone **1** (block **1746**) and control is returned to block **1408** (FIG. **14**). On the other hand, if the system **1000** determines at block **1740** that zone **5** is not substantially flat, then the system **1000** determines that zones **1** and **2** are to be adjusted by an amount equal to the average deviation of zone **1** (block **1748**) and control is returned to block **1408** (FIG. **14**).

FIGS. **19**–**25** are more detailed flow diagrams depicting an example manner in which the adjust conditioner method (block **1408**) of FIG. **14** may be implemented. In general, the example methods depicted in FIGS. **19**–**25** receive the zone change information from block **1406** and generate appropriate adjustment commands, instructions and/or signals that cause the material conditioner **1002** (FIG. **10**) to adjust its work rolls **1004** (FIG. **10**) to achieve a desired material condition, which in this example is a substantially flat condition. In particular, zone change information includes the zone(s) to be changed and the amount of change required (e.g., the average deviation of a particular zone). The particular manner in which the zone change information is processed by the system **1000** is based on which zone(s) are to be changed. Thus, adjustments to zones **3**, **1** and **4** only are carried out using the methods of FIGS. **19**, **20** and **21**, respectively. Simultaneous adjustments to zones **1** and **5** are carried out using the method depicted in FIG. **22**. Simultaneous adjustments to zones **1** and **2** are carried out using the method depicted in FIG. **23**. Simultaneous adjustments to zones **1** and **3** are carried out using the method depicted in FIG. **24**, and adjustments to zone **5** are carried out using the method shown in FIG. **25**.

Also, generally, the methods of FIGS. **19**–**25** determine the relative size of the adjustment to be made and select one of two adjustment step size sets based on the size of the adjustment to be made. The step size sets are amounts by which the adjustable backup bearings **1006** (FIG. **10**) and, thus, the work rolls **1004** (FIG. **10**) of the material conditioner **1002** (FIG. **10**) are moved during an adjustment interval. The step size sets may be selected to optimize the ability of the system **1000** (FIG. **10**) to quickly change the work roll profiles to achieve a desired material condition, without resulting in excessive overshoot, oscillation, etc. In general, larger step sizes enable a more rapid adjustment toward a desired material condition, while smaller step sizes enable more accurate control of the material condition. The methods of FIGS. **19**–**25** use two different sets of step sizes so that, initially, if the deviation from a desired material condition (e.g., substantial flatness) is relatively large (e.g., the average deviation value for a zone is relatively large), the set having larger step sizes is used. If the average deviation for a zone to be adjusted is initially relatively small or is reduced via prior adjustments (e.g., using a large step size adjustment), the set having the smaller step sizes may be used. In this manner, the example methods of FIGS. **19**–**25** provide the benefit of fast adjustment when deviations from a desired material condition are large and the benefits of greater precision as the deviations are reduced.

Now turning in detail to FIG. **19**, an example manner by which a command or determination to adjust zone **3** by an amount "AVG" initializes the settings of the material conditioner **1002** (block **1900**). At block **1902**, the system **1000** determines if the amount zone **3** is to be adjusted (i.e., AVG) is greater than a threshold value (i.e., Limit 2) representative of a relatively large adjustment amount. If the value of AVG exceeds the threshold value (Limit 2), then zone **1** is adjusted up by a first step amount (STEP2) (block **1904**), zone **2** is adjusted down by a second step (STEP 1) (block **1906**) and zone **5** is adjusted up by the first step (Step 2) amount (block **1908**).

At block **1910**, the system **1000** determines if the adjustment value AVG is greater than another limit or threshold (Limit 2) representative of a relatively smaller adjustment (i.e., in comparison to the threshold used in block **1902**). If the adjustment value AVG is greater than the other threshold (Limit 1), then zone **1** is adjusted up by an amount equal to STEP 1, zone **3** is adjusted down by an amount equal to STEP 1/2, and zone **5** is adjusted up by an amount equal to STEP 1.

The methods of FIGS. **20**–**25** are similar to those shown in FIG. **19** and, thus, are not described in additional detail herein. Any desired step sizes may be used with the methods of FIGS. **19**–**25**. However, in some examples, the value of STEP2 may be double the value of STEP1, which is double the value of STEP1/2. Of course, other relative step sizes or relationships and/or more than or fewer than three step sizes may be used if desired.

Although the description herein discloses example systems including, among other components, software executed on hardware, it should be noted that such systems are merely illustrative and should not be considered as limiting. For example, it is contemplated that any or all of the disclosed hardware and software components could be embodied exclusively in dedicated hardware, exclusively in software, exclusively in firmware or in some combination of hardware, firmware and/or software.

Although certain methods, apparatus, and articles of manufacture have been described herein, the scope of coverage of this patent is not limited thereto. On the contrary, this patent covers all apparatus, methods, and articles of manufacture fairly falling within the scope of the appended claims either literally or under the doctrine of equivalents.

What is claimed is:

1. A method for modifying a condition of a material, comprising:

obtaining a plurality of sensor readings associated with a plurality of longitudinal zones along a length of the material as the material moves;

acquiring travel length information associated with the material as the material moves;

determining a difference between a first wave height of the material in a first one of the longitudinal zones and a second wave height of the material in a second one of the longitudinal zones based on at least some of the plurality of sensor readings; and

adjusting a load applied to the material as the material moves based on the travel length information and the difference between the first and second wave heights to modify the condition of the material toward a desired condition.

2. A method as defined in claim **1**, wherein acquiring the travel length information includes measuring the travel length of the material as the material moves.

3. A method as defined in claim **1**, further comprising generating topographical information associated with a surface of the material based on the travel length information and the plurality of sensor readings.

4. A method as defined in claim **1**, further comprising determining a certification level of the material based on the plurality of sensor readings.

5. A method as defined in claim **1**, wherein the plurality of sensor readings are generated by at least one of a contact sensor or a non-contact sensor.

6. A method as defined in claim **1**, wherein adjusting the load applied to the material includes adjusting a position of a workroll to vary the load applied to the material.

7. A method as defined in claim **1**, wherein the material is a strip material.

8. A system for modifying the flatness properties of a continuously moving material, the system comprising:

a processor system; and

a memory communicatively coupled to the processor system, the memory including stored instructions that enable the processor system to:

obtain a plurality of sensor readings associated with a plurality of longitudinal zones along a length of the material as the material moves;

acquire travel length information associated with the material as the material moves;

determine a difference between a first wave height of the material in a first one of the longitudinal zones and a second wave height of the material in a second one of the longitudinal zones based on at least some of the plurality of sensor readings; and

adjust a load applied to the material as the material moves based on die travel length information and the difference between the first and second wave heights to modify the condition of the material toward a desired condition.

9. A system as defined in claim **8**, wherein the stored instructions enable the processor system to acquire the travel length information by measuring the travel length of the material as the material moves.

10. A system as defined in claim **8**, wherein the stored instructions enable the processor system to generate topographical information associated with a surface of the material based on the travel length information and the plurality of sensor readings.

11. A system as defined in claim **8**, wherein the stored instructions enable the processor system to determine a certification level of the material based on the plurality of sensor readings.

12. A system as defined in claim **8**, wherein the plurality of sensor readings are generated by at least one of a contact sensor or a non-contact sensor.

13. A system as defined in claim **8**, wherein the stored instructions enable the processor system to adjust a position of a workroll to vary the load applied to the material.

14. A system as defined in claim **8**, wherein the material is a strip material.

15. A machine accessible medium having instructions stored thereon that, when executed, cause a machine to:

obtain a plurality of sensor readings associated with a plurality of longitudinal zones along a length of the material as the material moves;

acquire travel length information associated with the material as the material moves;

determine a difference between a first wave height of the material in a first one of the longitudinal zones arid a second wave height of the material in a second one of the longitudinal zones based on at least some of the plurality of sensor readings; and

adjust a load applied to the material as the material moves based on the travel length information and the difference between the first and second wave heights to modify the condition of the material toward a desired condition.

16. A machine accessible medium as defined in claim **15** having instructions stored thereon that, when executed, cause the machine to acquire travel length information by measuring the travel length of the material as the material moves.

17. A machine accessible medium as defined in claim **15** having instructions stored thereon that, when executed, cause the machine to generate topographical information associated with a surface of the material based on the travel length information and the plurality of sensor readings.

18. A machine accessible medium as defined in claim **15** having instructions stored thereon that, when executed, cause the machine to determine a certification level of the material based on the plurality of sensor readings.

19. A machine accessible medium as defined in claim **15** having instructions stored thereon that, when executed, cause the machine to obtain the plurality of sensor readings from at least one of a contact sensor and a non-contact sensor.

20. A machine accessible medium as defined in claim **15** having instructions stored thereon that, when executed, cause the machine to adjust a position of a workroll to vary the load applied to the material.

21. A system for conditioning a moving material, the system comprising:

a first sensor corresponding to a first longitudinal zone of the moving material and separated by a first distance from a surface of the moving material;

a second sensor corresponding to a second longitudinal zone of the moving material and separated by a second distance from the surface of the moving material;

a controller communicatively coupled to the first and second sensors and configured to compare the first distance to the second distance; and

a roller operatively coupled to the controller, wherein the controller varies a position of the roller based on die comparison to vary a load applied to the moving material to condition the moving material.

22. A system as defined in claim **21**, further comprising an encoder communicatively coupled to the controller and configured to measure a travel length value associated with the moving material.

23. A system as defined in claim **21**, wherein the first sensor is one of a contact sensor or a non-contact sensor.

24. A system as defined in claim **21**, wherein the moving material is a strip material.

25. A system as defined in claim **21**, wherein the load is associated with at least one of a threshold distance value and an average distance value generated based on at least one of the first distance or the second distance.

26. A method of leveling strip material, the method comprising:

moving the strip material past a first sensor associated with a first longitudinal zone along a length of the strip material and a second sensor associated with a second longitudinal zone along the length of the strip material;

obtaining a first plurality of readings from the first sensor;

obtaining a second plurality of readings from the second sensor;

determining a first wave height value based on at least one of the first plurality of readings and a second wave height value based on at least one of the second plurality of readings; and

generating an electrical signal to cause an adjustment of a load applied to the strip material in response to comparing the first and second wave height values.

27. A method as defined in claim **26**, wherein comparing the first and second wave height values includes:

determining a first average for the first plurality of readings;

determining a second average for the second plurality of readings; and

determining a difference between the first average and the second average.

28. A method as defined in claim **26**, wherein moving the strip material past the first sensor and the second sensor comprises moving the strip material past at least one non-contact sensor.

29. A method as defined in claim **26**, wherein moving the strip material past the first sensor and the second sensor comprises moving the strip material past at least one of an acoustic sensor, an optical sensor, or a riding needle sensor.

30. A method as defined in claim **26**, further comprising determining a length associated with the strip material based on an input from an encoder.

31. A method as defined in claim **26**, wherein causing the adjustment of the load comprises causing a change in a workroll plunge.

32. A method as defined in claim **31**, wherein causing the change in the workroll plunge comprises adjusting a hydraulic cylinder operatively coupled to a backup bearing.

33. A method as defined in claim **26**, wherein causing the adjustment of the load comprises causing a change in a workroll center distance.

34. An apparatus to condition a material, comprising:

a roller configured to condition the material;

a first sensor corresponding to a first longitudinal zone of the material and positioned to measure a first height value of a surface of the material;

a second sensor corresponding to a second longitudinal zone of the material and positioned to measure a second height value of the surface of the material; and

a controller operatively coupled to the roller and the first and second sensors, wherein the controller is configured to generate an electrical signal in response to a comparison of the first height value and the second height value to condition the material.

35. An apparatus as defined in claim **34**, further comprising a hydraulic cylinder operatively coupled to the controller and configured to adjust the roller in response to the electrical signal.

36. An apparatus as defined in claim **35**, further comprising a backup bearing operatively coupled to the hydraulic cylinder and the roller, wherein the backup bearing causes a change in a plunge associated with the roller.

37. An apparatus as defined in claim **34**, wherein the first sensor comprises an acoustic sensor.

38. An apparatus as defined in claim **34**, wherein the first sensor comprises an optical sensor.

39. An apparatus as defined in claim **34**, further comprising an encoder operatively coupled to the controller, wherein the controller is configured to use the encoder to determine a distance between a first height measuring location and a second height measuring location.

40. An apparatus as defined in claim **34**, wherein the controller is configured to cause the generation of certification information associated with the material.

41. An apparatus as defined in claim **40**, further comprising a printer operatively coupled to the controller to print at least some of the certification information.

42. An apparatus as defined in claim **40**, further comprising a display device operatively coupled to the controller to display at least some of the certification information.

43. A method of modifying a condition of a material, comprising:

obtaining a first deviation value of a first wave height value associated with a first longitudinal zone of the material as the material moves;

obtaining a second deviation value of a second wave height value associated with a second longitudinal zone of the material as the material moves; and

adjusting a load applied to the first longitudinal zone of the material based on a comparison of the first and second deviation values.

44. A method as defined in claim **43**, wherein the first deviation value is obtained by determining a first average deviation based on a first plurality of sensor readings associated with the first zone of the material, and wherein the second deviation value is obtained by determining a second average deviation based on a second plurality of sensor readings associated with the second zone of the material.

45. A method as defined in claim **43**, wherein adjusting the load applied to the first zone of the material comprises determining that the first zone of the material is not flatter than the second zone of the material based on the comparison of the first and second deviation values.

46. A method as defined in claim **43**, wherein the first deviation value is represented using a first I-unit value and the second deviation value is represented using a second I-unit value.

47. A method as defined in claim **46**, wherein the first I-unit value is determined based on a peak value and a span value associated with the first zone.

48. A method as defined in claim 47, wherein the peak value is calculated by multiplying a first zone average value by two and subtracting the known thickness of the material from the result of the multiplication.

49. A method as defined in claim 47, wherein the span value is calculated by dividing a length of the first zone by a number of peaks in the first zone.

50. A method as defined in claim 43, wherein adjusting the load applied to the first zone comprises adjusting the load applied to the first zone and a third zone based on the comparison of the first and second deviation values.

51. A method of modifying a condition of a material, comprising:

obtaining a first plurality of sensor readings associated with a first zone of the material as the material moves;

obtaining a second plurality of sensor readings associated with a second zone of the material as the material moves;

determining a first height value based on the first plurality of sensor readings;

determining a second height value based on the second plurality of sensor readings; and

adjusting a load applied to the material in the second zone to condition the material in the first zone as the material moves based on a comparison of the first and second height values.

52. A method as defined in claim 51, wherein each of the first and second height values is selected from the group consisting of an average deviation value, a maximum deviation value, an I-unit, and a square root of a sum of squares of deviation values.

53. A method as defined in claim 51, further comprising acquiring a travel length value associated with the material as the material moves and adjusting the load applied to the second zone of the material based on the travel length value.

54. A method as defined in claim 51, further comprising comparing the first and second height values to a predetermined threshold value associated with a substantially flat condition and adjusting the load applied to the second zone of the material based on the comparison of the first and second height values to the predetermined threshold value.

55. A method of modifying a condition of a material, comprising:

determining a peak value based on an average deviation value associated with a first zone of the material as the material moves;

dividing the peak value by a length of the first zone to determine a quotient value;

determining a first I-unit value indicative of the condition of the material based on the quotient value;

comparing the first I-unit value to an I-unit threshold value associated with a desired condition of the material; and

adjusting a load applied to a second zone of the material as the material moves based on the comparison of the first I-unit value to the I-unit threshold value.

56. A method as defined in claim 55, further comprising determining a certification level of the material based on the first I-unit value.

57. A method as defined in claim 55, further comprising adjusting a third zone of the material as the material moves based on the comparison of the first I-unit value to the I-unit threshold value.

58. A method as defined in claim 55, further comprising:

determining a third 1-unit value associated with a third zone of the material and a fourth I-unit value associated with a fourth zone of the material as die material moves;

comparing the third I-unit value to the fourth I-unit value; and

adjusting another load applied to the third zone of the material as the material moves based on the comparison of the third and fourth I-unit values.

59. A method as defined in claim 58, wherein the load applied to the other zone of the material is adjusted based on a surface deviation value.

60. An apparatus to condition a material, comprising:

a workroll having a plurality of workroll zones spaced along a length of the workroll, wherein the length of the workroll is configured to traverse a width of the material, and wherein the workroll is configured to engage a surface of the material;

a first backup bearing configured to engage the workroll at a first workroll zone;

a second backup bearing configured to engage the workroll at a second workroll zone, wherein a first plunge of the first backup bearing is controllable independent of a second plunge of the second backup bearing;

a first sensor configured to obtain a first measurement value corresponding to a first wave height value associated with a first longitudinal zone of the surface of the material;

a second sensor configured to obtain a second measurement value corresponding to a second wave height value associated with a second longitudinal zone of the surface of the material; and

a controller configured to compare the first wave height value to the second wave height value and vary the first plunge of the first backup bearing by a first amount and the second plunge of the second backup bearing by a second amount based on the comparison to condition the material along the first longitudinal zone differently from the material along the second longitudinal zone.

61. An apparatus as defined in claim 60, wherein the controller is further configured to determine the first wave height value by averaging the first measurement value with a third measurement value obtained by the first sensor and to determine the second wave height value by averaging the second measurement value with a fourth measurement value obtained by the second sensor.

62. An apparatus as defined in claim 60, wherein the controller is further configured to determine that the first longitudinal zone of the material is substantially flatter than the second longitudinal zone of the material based on the comparison of the first and second wave height values and to vary the first plunge of the first backup bearing by the first amount and the second plunge of the second backup bearing by the second amount based on the determination that the first longitudinal zone of the material is substantially flatter than the second longitudinal zone of the material.

63. An apparatus as defined in claim 60, wherein the first backup bearing corresponds to the first longitudinal zone of the material and the second backup bearing corresponds to the second longitudinal zone of the material.

64. An apparatus as defined in claim 60, wherein the controller is configured to vary the first plunge of the first backup bearing by the first amount and the second plunge of the second backup bearing by the second amount to increase a first force applied to the first longitudinal zone of the material and to increase a second force applied to the second

longitudinal zone of the material, wherein the first force is different from the second force.

65. An apparatus as defined in claim **60**, wherein the controller is further configured to determine the first amount corresponding to the first plunge of the first backup bearing by comparing the first wave height value to a threshold value and determining the first amount based on the comparison.

66. An apparatus as defined in claim **65**, wherein the first wave height value is an average deviation value, and wherein the controller is further configured to determine the average deviation value by averaging the first measurement value with a third measurement value obtained by the first sensor.

67. An apparatus as defined in claim **65**, wherein the controller is further configured to select the first amount to vary the first plunge when the first wave height value is less than the threshold value and to select a third amount to vary the first plunge when the first wave height value is greater than the threshold value.

68. An apparatus to condition a material, comprising:

a sensor configured to obtain a first measurement value corresponding to a first zone of the material as the material moves; and

a controller configured to:

determine an average deviation value associated with the first zone of the material based on the first measurement value,

determine a peak value based on the average deviation value associated with a first zone,

divide the peak value by a length of the first zone to determine a quotient value,

determine a second value indicative of the condition of the material based on the quotient value,

compare the second value to a threshold value associated with a desired condition of the material, and

generate an electrical signal to adjust a load applied to a second zone of the material as the material moves based on the comparison of the second value to the threshold value.

69. An apparatus as defined in claim **68**, wherein the controller is further configured to communicate the electrical signal to a material conditioner having a roll configured to engage the material, wherein the electrical signal is configured to cause the material conditioner to adjust the load applied to the second zone of the material as the material moves by adjusting a plunge of the roll.

70. An apparatus as defined in claim **69**, wherein the roll includes a plurality of roll zones spaced along a length of the roll, and wherein the material conditioner further includes a first backup bearing configured to engage the roll at a first roll zone and a second backup bearing configured to engage the roll at a second roll zone, and wherein the controller is configured to cause the material conditioner to adjust the plunge of the roll by adjusting the first backup bearing independent of the second backup bearing based on the electrical signal.

71. An apparatus as defined in claim **68**, wherein the second value is an I-unit value.

72. An apparatus as defined in claim **68**, wherein the controller is further configured to determine a certification level of the material based on the second value.

73. An apparatus as defined in claim **68**, wherein the first zone is a first longitudinal zone of the material, wherein the apparatus further comprises a second sensor configured to obtain a second measurement value corresponding to a second longitudinal zone of the material as the material moves, and wherein the controller is further configured to:

determine a second average deviation value associated with the second longitudinal zone of the material based on the second measurement value;

determine a third value indicative of the condition of the material along the second longitudinal zone; and

generate the electrical signal to adjust the load applied to the second zone based on a comparison of the second value and the third value and the comparison of the second value to the threshold value.

* * * * *

UNITED STATES PATENT AND TRADEMARK OFFICE

CERTIFICATE OF CORRECTION

PATENT NO. : 7,185,519 B2
APPLICATION NO. : 10/662567
DATED : September 15, 2003
INVENTOR(S) : John Dennis Clark

It is certified that error appears in the above-identified patent and that said Letters Patent is hereby corrected as shown below:

Col. 21, line 60, after "on" insert --the-- delete "die".

Col. 22, line 26, after "zones" insert --and-- delete "arid".

Col. 23, line 5, after "on" insert --the-- delete "die".

Signed and Sealed this

Sixteenth Day of December, 2008

JON W. DUDAS
Director of the United States Patent and Trademark Office

UNITED STATES PATENT AND TRADEMARK OFFICE

CERTIFICATE OF CORRECTION

PATENT NO. : 7,185,519 B2
APPLICATION NO. : 10/662567
DATED : March 6, 2007
INVENTOR(S) : John Dennis Clark

It is certified that error appears in the above-identified patent and that said Letters Patent is hereby corrected as shown below:

Col. 21, line 60, after “on” insert --the-- delete “die”.

Col. 22, line 26, after “zones” insert --and-- delete “arid”.

Col. 23, line 5, after “on” insert --the-- delete “die”.

This certificate supersedes the Certificate of Correction issued December 16, 2008.

Signed and Sealed this

Sixth Day of January, 2009

Jon W. Dudas

JON W. DUDAS
Director of the United States Patent and Trademark Office

UNITED STATES PATENT AND TRADEMARK OFFICE
Certificate

Patent No. 7,185,519 B2 Patented: March 6, 2007

On petition requesting issuance of a certificate for correction of inventorship pursuant to 35 U.S.C. 256, it has been found that the above identified patent, through error and without any deceptive intent, improperly sets forth the inventorship.

Accordingly, it is hereby certified that the correct inventorship of this patent is: John Dennis Clark, McPherson, KS (US); and Clarence B. Cox, III, McPherson, KS (KS).

Signed and Sealed this Fifth Day of February 2013.

DANA ROSS
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